

SPEM 0010

Electrode for high strength and extreme crack resistance

ALLOY BASIS

Ni, Cr, Mn, Fe

PROPERTIES

A medium heavy coated, rutile type all-position electrode giving 30/10 deposit which has excellent oxidation resistance. The weld metal has a two phase structure with substantial amount of ferrite in the austenitic matrix. The deposited weld metal is highly resistance to weld metal cracks and fissures. Gives a quite and stable arc, low spatter, smooth weld bead and easily detachable slag. The weld metal meets radio graphic, X-ray, ultrasonic and other code requirements.

TECHNICAL DATA

UTS : 67-87 kgf/mm²
Elongation (L=4D) : 22-30%



TYPICAL APPLICATIONS

Heavy machinery parts, earth moving equipment parts, automobile springs, trunnions of cement mill & other allied components, parts subject to heat, corrosion & impact. Joining of high carbon, low & high alloy steels, tool steels, spring steels, manganese steels, case hardening steels, high speed steels, cast steels & for difficult to weld steels & unidentified steels, dissimilar steels. Also best suited for the joining of such steels with one another.. Also suitable for cushioning alloy under hard deposits.

PROCEDURE

- Keep electrode dry.
- Redrying at 300 °C for 1hr. is recommended.
- Do not exceed recommended current limit.
- Hold short arc. Ensure good fit-up of joints.
- Adopt proper sequence.

WELDING CURRENT

Current	: AC / DC (+)		
Size (∅ mm)/Length	: 2.5x350	3.2x350	4.0x350
Current (amps)	: 45-75	90-110	100-140



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