

R-680

A unique Austenitic-ferritic low heat input welding electrode for combination of high tensile strength

Basis OF Alloys : C, Mn, Cr, Ni

Application & Descriptions : A unique Austenitic-ferritic low heat input welding electrode for combination of high tensile strength and weldability. Electrode is controlled grain structure and ferritic. Weld metals offers superb combination of high strength, crack resistance, ductility and weldability.

For joining difficult-to-weld steel and dissimilar steels such as dies, tool and spring steels and joining steel to unknown composition, also used as cushion layer on difficult steels to weld steel before depositing final hard facing layer.

RE-DRY CONDITION : Re-Dry the electrode at 350°C for 1 hour,

ALL WELD MECHENICAL PROPERIES (TYPICAL):

| UTS | Elongation | HARDNESS |
|-----------------------|------------|-------------------|
| 800 N/mm ² | 22% | AS WELDED 220 BHN |

DIEMENSION, CURRENT CONDITION & PACKING DATA:

| Size(mm) (Dia) | Size(inch) (Dia) | Current Condition (DC+/ AC) Amps | weight of packet (Kgs) | Weight of Case |
|-------------------|---------------------|-------------------------------------|------------------------------|----------------|
| 2.50x350mm | 3/32"X14" | 50-80 | 2 | 20 |
| 3.20x350 | 1/8"X14" | 70-110 | 2 | 20 |
| 4.00x350 | 5/32"X14" | 100-130 | 2 | 20 |
| 5.00X350 | 3/16"X14" | 130-160 | 2 | 20 |

Customer packing on request.