

## D&H 2553 (NS)

**CODIFICATION :**                      AWS :    SFA 5.4 E2553-16

### CHARACTERISTICS AND APPLICATIONS :

- Non-synthetic rutile coated electrode depositing duplex stainless steel weld metal.
- Weld metal consisting of austenite and ferrite matrix, which gives good toughness and freedom from weld cracking.
- A soft and smooth arc, which is easy to strike and re-strike.
- Better welder appeal including, easy slag detachability characteristics.

The electrode can be used where resistance to pitting corrosive attack and resistance to stress corrosion cracking are required. The major application area includes, oil & gas industry, offshore platforms, petrochemical plants, mechanical & structural components demanding high strength together with high corrosion resistance.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	N
Percent :	0.025	1.1	0.45	0.010	0.012	25.0	7.5	3.3	2.0	0.17

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (MPa)	Elongation (L = 4d)%
752	25.0

### CURRENT AND PACKING DATA : AC / DC(+)

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	150-180	110-140	80-100	60-80
Weight/Carton (kgs)	2.5	2.5	2.5	2.5

### PRECAUTIONS :

1. The electrodes should be kept dry. In case of moisture pick-up re-dry the electrodes at 250-300°C for one hour.
2. Use stringer beads, short arc and smallest possible size, which helps in reducing the heat input.

**Note:** D&H 2553-15(NS) conforming to AWS E2553-15 is also available.