Estd. 1966
D&H sécheron
Complete Welding Support

50 YEARS 1968 - 2018

D&H 383

CODIFICATION: AWS : SFA 5.4 E383-16

CHARACTERISTICS AND APPLICATIONS :

• Non-synthetic electrode depositing low carbon 28Cr-31.5Ni-3.7Mo-1Cu, fully austenitic weld metal. • Weld metal exhibits excellent resistance to corrosion in non-oxidizing media like Sulfuric acid, Phosphoric acid, etc. • The elements C, P and S are maintained at low levels to eliminate hot cracking & fissuring problems in weld metal. • A soft and smooth arc, which is easy to strike and re-strike. • Easy slag detachability and well-rippled weld beads. • The weld metal is of radiographic quality.

Ideally suited for welding stainless steels of similar composition and other equivalent grades of stainless steels.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element :	C	Mn	Si	Cr	Ni	Mo	P	S	Cu
Percent :	0.025	1.5	0.90	27.7	31.5	3.7	0.010	0.005	1.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L = 4d)%
574	35.0

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm) Dia x Length	:	5x350	4x350	3.15x350	2.5x350
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 383-15 conforming to **AWS E383-15** is also available.