

D&H 415

CHARACTERISTICS AND APPLICATIONS :

D&H 415 is a rutile type electrode producing a ferritic stainless steel weld deposit. The deposit has good resistance to abrasion, erosion, corrosion and heat. Ideally suited for rebuilding of refiner cones and shells in paper mills, surfacing of industrial valves, surfacing of parts in brewery industry.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	: C	Mn	Si	Cr
Percent	: 0.08	0.60	0.60	17.00

WELD METAL HARDNESS: 275-325 VPN

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	: 5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	: 180-250	150-180	100-140	80-100
Weight/Carton (kgs)	: 2.5	2.5	2.5	2.5

PRECAUTIONS:

1. Ensure the electrodes are dry. In case of moisture pick-up, redry the electrodes at 200-250°C for one hour.
2. Use short arc and minimum heat input.