

D&H 535

CHARACTERISTICS AND APPLICATIONS :

- A heavy coated, hydrogen controlled, all conventional position electrode depositing low alloy weld metal.
- The electrode gives soft & smooth arc which is easy to strike & re-strike.
- Superior operating characteristics with easy slag detachability.
- The welds are of radiographic quality.
- For surfacing of hot forging dies.
- For repairs of large hot working dies and earth moving equipments made of high tensile steel.
- Repair of case hardening steel parts after removing the hard zones, for repairing cracks in Ni-Cr hot working dies.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	C	Mn	Si	Cr	Ni	Mo	V
Percent	0.09	1.55	0.45	2.80	2.25	1.20	0.30

WELD METAL HARDNESS (ON 3 LAYERS):

After SR 560°C for one hour: 36-39 RC

CURRENT AND PACKING DATA : AC / DC(+)

Size (mm)	:	8x450	6.3x450	5x450	4x450
Dia x Length					
Current Range (Amps)	:	300-350	250-280	200-250	150-180
Weight/Carton (kgs)	:	5	5	5	5

PRECAUTIONS:

1. The electrodes should be dry. Redry the moisture electrodes at 250°C for one hour.
2. When welding on high hardenable materials of large thicknesses, adequate care for preheating, slow cooling & PWHT are necessary.
3. Use short arc & minimum weaving.