

## R-109

### Basic coated, Hydrogen controlled iron powder type Electrode for high tensile steels

**Basis OF Alloys** : C, Si, Mn, Cr, Mo

**Application & Descriptions :** An extra low hydrogen low heat input welding electrode. Weld metal is tough, ductile and crack resistant. It can be used in all positions. Excellent impact strength at --51°C temperature.

Ideal for repair and maintenance of high strength steels, Q&T steels, case hardened steels, and heat treated steels. For welding pressure vessels, fabrication and repair of heavy machinery parts, repairs of dams, power station machineries storage tanks for liquefied gases, rolls shafts & gears wheels.

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

#### **ALL WELD MECHENICAL PROPERIES (TYPICAL):**

UTS	Elongation	Impact at -50°C
<b>700 N/mm2</b>	28%	<b>50 jouls</b>

#### **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"	50-90	4	16
3.20x350	1/8"X14"	100-140	4	16
4.00x350	5/32"X14"	140-190	5	20
5.00X350	3/16"X14"	180-230	5	20

Customer packing on request.