



MODI SS-Mn

STAINLESS STEEL ELECTRODE

CLASSIFICATION :

IS : 5206-83 : E 18.8 Mn R 26
AWS/A 5.4 : NEAREST TO 307

CHARACTERISTICS :

A stainless steel electrode for variety of applications, in all Conventional positions. Core wire is 18/8 grade stainless steel. Weld metal is austenitic stainless steel, non-magnetic and has good abrasion as well as wear resistance. Resistance to scaling upto a temperature of 850°C is excellent.

APPLICATIONS :

- * Joining stainless steel of similar composition.
- * Welding Austenitic steel to ferritic steels.
- * Joining Austenitic Manganese steel to other steels.
- * Suitable for buffer layers and Hard surfacing Application.

RECOMMENDATIONS :

Re-dry the electrodes at 200°C for one hour. Use low current and short arc. Avoid preheat/overheat in case of austenitic manganese steels. Use stainless steel wire brush for cleaning the welds.

**CHEMICAL ANALYSIS
OF WELD-METAL(%) :**

C	Mn	Si	Cr	Ni	Mo	S	P
0.12	5-8	0.9	17-20	7-10	0.5	0.03	0.04
max		max			max	max	max

**MECHANICAL PROP-
ERTIES OF ALL WELD-
METAL (AS PER
AWS/A 5.4) :**

Ultimate Tensile Strength N/mm ²	Elongation (%)
600-650	30-40

CURRENT CONDITIONS : USE AC OR DC (+)

Size (mm)	2.5x350	3.15x350	4.0x350	5.0x350
Amps	60-80	80-110	110-140	150-180

SPECIAL CHARACTERISTICS :

HARDNESS : As deposited : 170-200 BHN
Work hardness : 450 BHN max

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