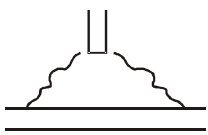


NPH	FLUX COATED MMA ELECTRODE FOR PRE-HEATING AWKWARD WELD JOINT CONFIGURATIONS			DATA SHEET NO. 155	
SPECIFICATION	NO NATIONAL SPECIFICATIONS				
CLASSIFICATION					
PRODUCT DESCRIPTION	The extruded flux coating is a blend of thermally stable metal oxides combined with metals which have a relatively low free energy of oxide formation that results in pre-heating arc that does not melt the base material.				
WELDING FEATURES OF THE ELECTRODE	Opposed to normal electrodes, a large length arc is established which is stable both AC and DC. The energy dissipated into the base material causes it to gradually warm without causing it to melt. Electrode consumption per time unit of usage compared to welding electrodes is very low.				
APPLICATIONS	Used solely for the purpose of applying moderate pre-heat to stresses welding preparations when circumstances or location prevent conventional methods being used. For maximum benefit, pre-heat not only the weld preparation but also adjacent areas.				
WELD METAL ANALYSIS COMPOSITION % BY Wt.	NOT RELEVANT				
WELD METAL PROPERTIES (ALL WELD METAL)	NOT RELEVANT				
WELDING AMPERAGE AC or DC+	Ø (mm)	3.2	4.0	5.0	
	MIN	150	230	290	
	MAX	200	290	330	
OTHER DATA	Electrodes that have become damp should be re-dried at 100°C for 30 minutes.				