


NS-20Cr	LOW-CARBON 20% CHROME -NICKEL FREE ELECTRODE				DATA SHEET NO. 148D				
	SPECIFICATION	BS 2926		DIN 8556					
CLASSIFICATION	20.RMP		E20 MPR 26 130						
PRODUCT DESCRIPTION	A special rutile based flux with a positive ratio of chemically basic minerals to acid minerals that contains all the major alloying elements which is extruded onto a high purity ferritic wire. The use of balanced silicates ensures both strength of coating and resistance to moisture absorption.								
WELDING FEATURES OF THE ELECTRODE	The arc stability is excellent on both AC and DC+ as is the electrodes ability for initial arc strike and re-striking. Spatter is minimal and the slag is readily detachable leaving smooth evenly rippled seams of pleasing appearance. Metal recovery is some 130% with respect to weight of the core wire.								
APPLICATIONS AND MATERIALS TO BE WELDED	For welding 26% chrome ferritic steel when excellent resistance to stress corrosion cracking in oxidising acids or in severe sulphidising condition needed which often found in production plant in the copper industry. Typical material includes : 442 steels – ASTM A 176 446 steels – ASTM A 276 This electrode suitable to used in condition which is unable to post weld heat treat. In all case, pre-heat temperature should be 150 to 200 °C, and interpass temperature must be as close to pre-heat temperature.								
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Cr	Mo	Fe
	MIN	-	-	-	-	-	20	-	
	MAX	0.1	1.0	1.0	0.02	0.02	22	0.5	
	TYPICAL	0.08	0.35	0.4	0.01	0.01	20.5	0.02	Bal.
WELD METAL PROPERTIES (ALL WELD METAL)	PROPERTY		UNITS	MINIMUM	TYPICAL	OTHERS			
	Tensile strength		N/mm ²	500	550	PWHT 760-820°C / 1h then rapid air cooled or PWHT 1100 °C / 1h furnace cool to 800 °C then water quench			
	0.2% Proof stress		N/mm ²	300	405				
	Elongation on 4d		%	-	12				
Elongation on 5d		%	-	16					
WELDING AMPERAGE AC or DC+	Ø (mm)	3.2		4.0	5.0				
	MIN	100	140	180					
	MAX	150	190	230					
OTHER DATA	Electrodes that have become damp should be re-dried at 150°C for 1 hour.								
RELATED PRODUCTS	Please contact our Technical Department for detail.								