

### Typical Applications:

- Designed for joining and repair of ASTM A148, A643, A757, HY-130, LQ-130, and Weldox 960 Steels
- Alloy Forging and Casting Repair
- Heavy Equipment Fabrication and Repair such as Cranes, Crane Booms, Excavators, Mining Equipment

### Product Advantages:

- High yield and tensile strength after PWHT
- Smooth, stable arc
- Good Toughness

### Typical Mechanical Properties

	UTS (ksi)	Yield (ksi)	%El	CVN(ft/lbs)@ -4°F	CVN(ft/lbs)@ -40°F
SR 1hr @ 1100°F	143	130	19	25	20

### Typical Deposit Composition

%C	%Mn	%Si	%Ni	%Mo	%Cr	%Cu
0.10 max	1.4 – 1.8	0.25 – 0.6	3 – 3.75	0.7 – 1.2	0.75 max	1.0 max

**Available Diameters:** 1/16" (Additional sizes may be available upon request)

### Typical Welding Parameters

Diameter	Shielding Gas	Amperage Range	Voltage	Current
1/16"	75 Ar / 25 CO2	220 – 250	27 – 28	DCEP

**Packaging:** The product is packaged on 25lb. spools with a vapor corrosion inhibitor strip, vacuum-packaged and placed in a specially designed carton for long-term storage.

### Moisture Control:

Devasco electrodes are manufactured and packaged to resist moisture pick up. Electrodes should be stored in their original packaging in a clean, dry, environment with a temperature range of 40°F to 120°F with a maximum humidity of 80%. However, under exposure to the elements, the fluxing components may begin to absorb moisture. All exposed and unused electrodes may be baked at 300-325°F in a warming oven for a minimum of 2 hours prior to use.

**NOTICE:** Data provided is based on typical results. **Actual results are tested per customer spec.** Please contact customer service at 888-DEVASCO for modified chemistries, welding parameters, PWHT conditions, or Safety Data Sheets. Specification subject to change without notice. [www.devasco.com](http://www.devasco.com) for additional information.

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