

Applications and Advantages:

- 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
- High yield and tensile strength after PWHT

Typical Mechanical Properties (Stress Relieved 3 hour at 1,100°F)			
UTS (ksi)	Yield (ksi)	%El	CVN(ft/lbs)@ -4°F
143	130	19	25

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 CO ₂	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 281-351-6555 for modified chemistries, welding parameters, PWHT conditions, or Safety Data Sheets. Specification subject to change without notice. www.devasco.com for additional information.
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