

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
- Flat bead with easy slag release
- Smooth, stable arc
- Good Toughness

Typical Mechanical Properties

	UTS (ksi)	Yield (ksi)	%El	CVN(ft/lbs)@ +72°F	CVN(ft/lbs)@ 0°F
SR 1hr @ 1125°F	149	130	19	46	25

Typical Deposit Composition

%C	%Mn	%Si	%Ni	%Mo	%Cr	%Cu
0.05 – 0.2	1 – 2	0.5 max	2 – 3	0.5 – 1.0	0.5 – 1.0	0.75 max

Available Diameters: 0.045", 1/16", 3/32" (Additional sizes may be available upon request)

Typical Welding Parameters

Diameter	Amperage Range	Voltage	Current
0.045"	150 – 200	26 – 27	DCEP
3/32"	300 – 350	28 – 29	DCEP

Packaging: The product is packaged on 60lb. coils 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 for additional information.

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