

Typical Applications:

- Fabrication/Repair High Strength steels such as ASTM A148, A643, A757, HY130, LQ130, and Weldox 960
- Alloy Forging and Casting Repair
- Heavy Equipment Fabrication and Repair such as Cranes, Crane Booms, Excavators, Mining Equipment

Product Advantages:

- All Position – Flat, Horizontal, Vertical
- Minimal moisture pickup
- Flat bead with easy slag release
- Low Spatter
- Consistent Arc Re-strike
- Low Hydrogen

Typical Mechanical Properties

	UTS (ksi)	Yield (ksi)	%El	CVN (ft/lbs)@-4F	CVN (ft/lbs)@-60F
As Welded	140	135	15	-	50
SR 1hr. @ 750°F	145	135	20	65	-

Deposit Composition Range

%C	%Mn	%Si	%Ni	%Mo	%Cr
0.05 – 0.15	1.0 – 1.5	0.5 max	2.5 – 3.5	0.5 – 1.0	0.5 – 1.0

Available Diameters: 1/8", 5/32", 3/16" (Additional sizes may be available upon request)

Typical Welding Parameters (DCEP)

Diameter	Amperage Range	Current
1/8"	120 – 160	DCEP
5/32"	150 – 200	DCEP
3/16"	200 – 275	DCEP
1/4"	300 – 400	DCEP

Packaging: Electrodes are vacuum-sealed in 10 lb. boxes in a climate-controlled room to eliminate all moisture and then placed in 40 lb. master cartons.

Moisture Control: Devasco electrodes are manufactured and packaged to resist moisture pick up. New or open electrodes should be stored in their original packaging (if heat resistant) in a storage oven at 300° F - 325° F with a maximum humidity of 70%. However, under exposure to the elements, the fluxing components may begin to absorb moisture. All exposed and unused electrodes may be baked at 500-800°F in a warming oven for a minimum of 1 hour for reconditioning 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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