

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:

- Flat, Horizontal Position Only
- Smooth Arc with low spatter
- Flat bead with easy slag release
- Good Toughness
- Low moisture pick-up
- 75%Ar/25%CO₂ shielding gas

Typical Mechanical Properties				
	UTS (ksi)	Yield (ksi)	%El	CVN (ft/lbs)@-4F
AWS Spec.	140	-	-	-
DevTek 140 SR 1.5 hr @750°F	144	136	17	37

Deposit Composition Range							
	%C	%Mn	%Si	%Ni	%Mo	%Cr	%Cu
DevTek 140	0.05 – 0.10	1.0 – 2.0	0.5 max	3.0 – 4.0	0.2 – 1.0	0.2 – 1.0	1.0 max

Available Diameters: 0.045" (Additional sizes may be available upon request)

Typical Welding Parameters			
Diameter	Amperage Range	Voltage	Current
0.045"	175 – 250	25 – 28	DCEP

Packaging: The product is packaged on 25 or 50lb. 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 for additional information.
Last Revised: March 25, 2021.