

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

Product Advantages:

- Flat, horizontal position only
- High yield and tensile strength
- Good toughness
- Low moisture pick-up

Typical Mechanical Properties					
	UTS (ksi)	Yield (ksi)	%El	CVN (ft/lbs) -20°F	CVN (ft/lbs) -40°F
AWS Spec.	150	-	-	-	-
DevTek 150 QT, Quench and Temper	154	142	15	30	-
DevTek 150 AT SR 3hr 1025°F	159	143	18	-	23

Deposit Composition Range							
	%C	%Mn	%Si	%Ni	%Mo	%Cr	%Cu
AWS Spec.	-	-	-	-	-	-	-
DevTek 150 QT	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: 1/16" (Additional sizes may be available upon request)

Typical Welding Parameters			
Diameter	Amperage Range	Voltage	Current
1/16"	245 – 275	27 – 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.
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