

Typical Applications:

- Designed for 5%Cr - .5%Mo Steels
- High Temperature Service
- Boiler and Pressure Vessels
- Power Piping, Steam Generation
- Petrochemical
- Repair and Maintenance of Castings

Product Advantages:

- Flat, Horizontal Position Only
- Smooth Arc with low spatter
- Flat bead with easy slag release
- Low moisture pick-up

Typical Mechanical Properties - Stress Relieved 2hr @ 1375° F			
	UTS (ksi)	Yield (ksi)	%El
AWS Spec	80-100	68	19
DevTek 80T5-B6	90	80	21

Typical Deposit Composition							
	%C	%Mn	%Si	%Ni	%Mo	%Cr	%Cu
AWS Spec. (Max.)	0.05 – 0.12	1.25	1.00	0.40	0.45 - 0.65	4.0 - 6.0	0.50

Available Diameters: 1/16” (Additional sizes may be available upon request)

Typical Welding Parameters			
Diameter	Amperage Range	Voltage	Current
1/16”	245 - 275	25 - 29	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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