

SPECTRUM 65D

(Low Heat Input welding alloy)

DESCRIPTION

Unique semi basic type low heat input welding electrodes for welding of difficult to weld and dissimilar alloys and high strength steels. The weld deposit are highly resistant to cracking makes this electrode suitable for critical applications. The weld deposit is corrosion resistance and also oxidation resists even at high temperature. Weld deposits provides excellent metal to metal friction resistance.

SPECIAL FEATURE

- ❖ Weld deposits are smooth with uniform controlled fine ripples and self detachable slag.
- ❖ Weld metal are duplex structure and are extremely tolerance to dilution.
- ❖ Excellent weldability, most suitable for high tensile safety repair and also as buffer layer for protective weld coating.
- ❖ Versatile electrodes operate at low amperage on both AC as well as in DC (+) welding equipments.

APPLICATIONS

Most suitable for weld joining of austenitic and ferritic steels, other alloy steels joining of dissimilar and difficult to weld steels. Weld deposit are highly resistant to crack hence idle electrode for coal mines (underground and open cart mines, weld repair application)

PROCEDURE

- ❖ Keep electrode dry
- ❖ Do not exceed recommended current limit
- ❖ Hold short arc, use good fit up of joints.
- ❖ Adopt proper sequence
- ❖ Hot peen to relieve stresses

TECHNICAL DATA

Tensile Strength - 845 N/mm²

OPERATION DATA: AC / DC (+)

Size(mm)	2.00 X 350	2.50 X 350	3.15 X 350	4.00 X 350	5.00 X 350
Current (Amps.)	40 – 55	55 – 75	75 – 105	100 – 130	120 – 150

NUCOR WELD (INDIA) PVT. LTD.

(An ISO 9001: 2008 Certified Company)

No. 9, KIADB Veerasandra Industrial Area, Electronic City Post,
Bangalore-560 100. India. Ph: 080-27848424/25/26, Fax: 080-27848173
E-mail: sales@nucorweldindia.com , Web site: www.nucorweldindia.com