

FEATURES

This alloy has good weld appearance and slag peels off by itself. It gives crack free weld deposit with higher strength. Weld metal is extremely ductile and of radiographic quality.

APPLICATIONS

Use for fabricating structures, pressure vessels, pipes, machinery, assemblies and repair of heavy duty off the road equipments. It is widely used in the forging industry for the repair of hammer bases, sow blocks, rams, bolster plates columns and keyways. Also used as an underlay prior to surfacing with higher alloys. For joining and built up of low and medium carbon steels. Ideal for joining dissimilar sections, restrained joints and oil soaked parts.

PROCEDURE

Clean weld area and remove fatigued metal. For horizontal welding use short arc and contact technique. Use weaving and welding from bottom to upper side for vertical joints. Use DC power source on reverse polarity. It is recommended to dry electrode at 300° C for one hour before use to get better results. Preheat is beneficial for heavy cast steel sections.

MMAW	FCAW	SAW
AC/DC+	DC+, 100%CO ₂	DC+, Use a neutral flux
	Or 75%Argon-25% CO ₂	

TECHNICAL DATA

Alloy Type	:	C,Mn,Si
Tensile Strength	:	550-650 N/mm ²
Elongation	:	24-28 %
Available Processes	:	MMAW, FCAW and SAW

RECOMMENDED CURRENT RANGE

ELECTRODES

SIZE (mm)	3.15	4.00	5.00
AMPS	90-130	140-170	180-230

FLUX CORED WIRES

SIZE (mm)	2.4	2.8	3.2
AMPS	330-370	370-410	500-540

CARVER 9525-LH

ALLOY FOR
 MEDIUM-TENSILE, DUCTILE STEEL WELDS