

CARVER 9895

FEATURES

Fully austenitic electrode with high strength and resistance to heat and corrosion. Scale resistance upto 1200° C. Deposit is tough, crack proof and wear resistant. It is suitable for positional welding.

APPLICATIONS

For joining and surfacing of all types of mild and alloyed steels, heat and scale resistant steels, manganese steels, and for joining dissimilar steels. For cushioning alloy under hardfacing deposit. For fabrication and repair of valves, rolls, gears, hot dies, gas turbines and parts subject to heat, corrosion and impact. Cladding side of SS clad sheets, furnace parts, hydrogenation plants.

PROCEDURE

Use either AC or DC, reverse polarity. Clean weld area. Prepare edges of heavy sections depending on thickness. Preheating depends on the composition of parent metal. Stinger bead technique with short arc is recommended. Deslag each and every pass for good penetration. Dry electrode for 2-3 hours at 300° C if necessary.

TECHNICAL DATA

Alloy Type	:	Fe, Cr, Ni, Mn Alloy
Tensile Strength	:	600 N/mm ²
Elongation	:	30-35 %
Hardness	:	Rockwell C 26-32

RECOMMENDED CURRENT RANGE

SIZE (mm)	2.5	3.15	4.00
AMPS	40-70	70-110	100-140

**ELECTRODE FOR
HIGH RESITANCE TO HEAT AND CORROSION**