

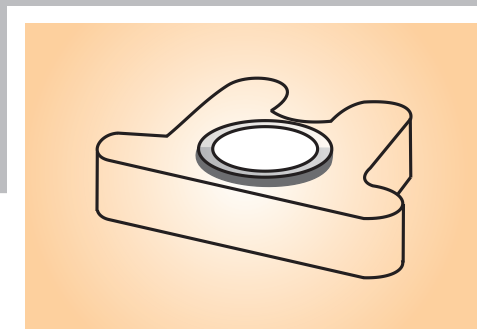
ESSEN® CN 116

AC/ DC +

High Alloy Steel electrodes For effective surface treatment

AWS/SFA 5.5 E 11016 G.IS E76 B G1 26

A Low Hydrogen electrode for repairs of Hot forging dies.



PROPERTIES

This low hydrogen type electrode gives smooth, spatter free arc and deposits alloy steel metal that have high tensile strength and moderate hardness. The deposited metal contains Cr, Ni, Mo and V in good percentage which makes the metal as most versatile in many critical application. The deposited metal is heat treatable and therefore the properties can still be increased. Deposits are dense and defect free, Slag is easily detachable..

MECHANICAL PROPERTIES

Tensile strength: 900 to 1000 N/MM² Elongation: 16%

Yield strength: 800 to 920 N/MM² Hardness: 280 to 350 BHN (Two layers)

APPLICATIONS

Suitable for joining and overlaying work in the forging and steel industries. Also suitable for hot working dies which are subjected to temperatures of 600° to 900°C., machinery components, joining of Armour steel plates, overlaying of steam turbine rotor shafts, chemical and automobile parts, earth moving machinery parts etc. Also as base layer before hard facing of hammers, buckets, rolls etc.

WELDING PROCEDURE.

Clean joint or welding area, preheat the joints if required, use low current, strike the arc on scrap piece and then carry over to the actual welding area, peen the weld metal after removing the flux, keep the joint temperature as constant as possible, slow cooling recommended.

RECOMMENDED AMPERAGE	
Size	Current
3.15mmx 350mm	110 - 130 Amps
4.00 mm x 450 mm	140 - 170 Amps
5.00 mm x 450 mm	180 - 210 Amps
6.30mm x 450 mm	210 - 300 Amps

PACKING	
3.15 mm x 350 mm 5 kg	31 pcs/kg (Approx.)
4.00 mm x 450 mm 5 kg	19 pcs/kg (Approx.)
5.00 mm x 450 mm 5 kg	16 pcs/kg (Approx.)
6.30 mm x 450 mm 5 kg	13 pcs/kg (Approx.)



ESSEN
WELDING ALLOYS PVT. LTD.



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PREMIUM WELDING ALLOYS

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