

AWS E 312-16
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 EN E 29 9 R 12

MTENSILE

For welding of dissimilar metals

Applications

Welding of 29%Cr-9%Ni cast steel, dissimilar metals such as carbon steel or low alloy steel to austenitic stainless steel.

Welding of AISI (SUS) 304 clad steel.

Under laying build up of hard surfacing.

Characteristics:

MTENSILE is a rutile covering type electrode for all-position welding, depositing weld metal of 29%Cr - 9%Ni. As the weld metal contains large quantity of ferrite, its crack resistibility is good. It is used for welding dissimilar metals and under laying welding of hard surfacing.

Notes on usage:

1. Choose the welding current as low as possible to prevent cracking of plate.
2. When the electrodes have absorbed moisture, dry them at 250-350 °C for 60-90 minutes before use.
3. Weaving width should be within two and a half times of electrode's diameter.
4. It is necessary to preheat the plate at 200 °C and over in the case of welding of special steel such as high alloy tool steels.

Typical chemical composition of weld metal (%)

C	Mn	Si	Cr	Ni
0.1	1.1	1	29	9

Typical mechanical properties of weld metal

0.2% proof stress (N/mm ²)	Elongation %	TS N/mm ²
450	20	750

Size & recommended current range: (~ =+)

Product name	Order number	Diameter (mm)	Length (mm)	Amp.
MTENSILE	332578	3.25	350	75-110
	332557	4.0	350	110-150

Welding Positions

