



D&H-3U

CHARACTERISTICS AND APPLICATIONS:

D&H-3U is a specially designed electrode for welding U3 steel. The weld metal has excellent crack resistance and has good scaling resistance. It produce quiet and stable arc, which is easy to strike and re-strike. Detachability of slag is very easy. The weld metal is of radiographic quality. Ideal for joining ferritic to austenitic steels, armour plates, austenitic manganese steels, dissimilar materials, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	S	P	Cr	Ni
Percent	: 0.04	4.5	0.42	0.020	0.020	17.20	9.50

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L = 4d)%
615	38.0

CURRENT & PACKING DATA: AC / DC (+)

Size (mm)	:	5 x 350	4 x 350	3.15 x 350	2.5 x 350
Dia x Length					
Current Range	:	150-180	110-150	70-100	50-70
(Amps)					
Quantity	:	2.5	2.5	2.5	2.5
(kgs/Carton)					

PRECAUTIONS:

1. Re-dry the electrodes at 250-300°C for one hour.
2. Use short arc, stringer beads, and low currents.