



D&H 2553 (NS)

CODIFICATION : AWS : SFA 5.4 E2553-16
 EN ISO : 3581-B E S 2553-16

CHARACTERISTICS AND APPLICATIONS :

- Non-synthetic rutile coated electrode depositing duplex stainless steel weld metal.
- Weld metal consisting of austenite and ferrite matrix, which gives good toughness and freedom from weld cracking.
- A soft and smooth arc, which is easy to strike and re-strike.
- Better welder appeal including, easy slag detachability characteristics.

The electrode can be used where resistance to pitting corrosive attack and resistance to stress corrosion cracking are required. The major application area includes, oil & gas industry, offshore platforms, petrochemical plants, mechanical & structural components demanding high strength together with high corrosion resistance.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

| Element : | C | Mn | Si | S | P | Cr | Ni | Mo | Cu | N |
|-----------|-------|-----|------|-------|-------|------|-----|-----|-----|------|
| Percent : | 0.025 | 1.1 | 0.45 | 0.010 | 0.012 | 25.0 | 7.5 | 3.3 | 2.0 | 0.17 |

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

| | |
|-------|------------|
| UTS | Elongation |
| (MPa) | (L = 5d)% |
| 782 | 25.0 |

CURRENT AND PACKING DATA : AC / DC(+)

| | | | | |
|---------------|-----------|---------|----------|---------|
| Size (mm) | : 5x350 | 4x350 | 3.15x350 | 2.5x350 |
| Dia x Length | | | | |
| Current Range | : 150-180 | 110-140 | 80-100 | 60-80 |
| (Amps) | | | | |
| Weight/Carton | : 2.5 | 2.5 | 2.5 | 2.5 |
| (kgs) | | | | |

APPROVAL: CE

PRECAUTIONS:

1. Ensure the electrodes are dry. Re-dry the electrodes at 250-300°C for one hour.
2. Use stringer beads, short arc and smallest possible size, which helps in reducing the heat input.

Note: D&H 2553-15 (NS) conforming to AWS E2553-15 is also available.