



SIA (N)

CHARACTERISTICS AND APPLICATIONS:

SIA (N) is a low-hydrogen type special stainless steel electrode depositing a stainless steel weld metal having 16Cr 8Ni - 8Mn - 0.4Mo 0.12N. The weld metal highly crack resistant and it has got high strength and good toughness properties even at different temperatures. Nitrogen alloying in this weld metal increases wear resistance and satisfy galling resistant requirements. It is ideally suited for resisting wear in particle to metal & metal-to-metal applications. It is also useful for producing stainless steel overlay for corrosion resistance, surfacing layers for hardfacing and work hardenable deposits.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	C	Mn	Si	Cr	Ni	Mo	S	P	N	V	W	Cb	Cu
Percent	: 0.07	8.0	0.90	16.5	8.2	0.42	0.014	0.026	0.12	0.10	0.10	0.02	0.02

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L= 4d)%
630	38.0

CURRENT AND PACKING DATA: AC / DC (+)

Size (mm)	: 6 x 350	5 x 350	4 x 350	3.15 x 350	2.5 x 350
Dia x Length					
Current Range (Amps)	: 220-270	170-200	130-170	90-130	60-90
Qty.(kgs/Carton)	: 3.0	2.5	2.5	2.5	2.5

PRECAUTIONS:

1. Re-dry the electrodes at 200-250°C for one hour.
2. Use short arc, lowest current possible.