

# SPECIAL ALLOYS FOR MAINTENANCE & REPAIR

## ELECTRODES

For High Alloy Steels / Manganese Steel /  
Stainless Steels Tools, Dies and Dissimilar Steels

### PRODUCT GOLD : 320



Descriptions	Technical Details	Ømm	List Price
Electrode with high manganese content. For repair welding on 14% manganese steels, welding of dissimilar steels, tool steels, spring steel and for buffer (under) layers before hard facing. Used in construction and earth moving, tool and die repairs, mining, quarries etc.	Rm (Mpa) : 600-750	2.6	
	Re (Mpa) : 400	3.2	
	A5 (%) : 30	4.0	
	Hardness : as welded ~200HB; Work hardened ~4a50HB		



### PRODUCT GOLD : 330

Descriptions	Technical Details	Ømm	List Price
Multipurpose high strength ferrite-austenitic electrode for repair welding on alloy and high-alloy-steels, tool-steels, stainless steels and dissimilar assemblies. Use for dies, moulds, press tools, crane booms, shafts, gears, rails armour plates buckets etc.	Rm (Mpa) : 800	2.6	
	Re (Mpa) : 550	3.2	
	A5 (%) : 25	4.0	
	Hardness : as welded ~240-280 HB Weld metal : Cr, Ni, Mn		

## ELECTRODES

For Stainless Steels

### PRODUCT GOLD : 310



Descriptions	Technical Details	Ømm	List Price
JOINING STAINLESS STEELS Highly alloyed, easy to weld stainless steel maintenance electrode, Cr-Ni-Mo with very low carbon, for welding 304, 304L, 347, 316L, 318 stainless steels at service temperatures of-120°C to 350°C. Industries using gold 310.  Chemical, pulp and paper processing, food processing, pharmaceuticals, breweries and soft drink, shipbuilding and repair, sheet metal fabrication, industrial.	Rm (Mpa) : 580	2.6	
	Re (Mpa) : 420	3.2	
	A5 (%) : 40	4.0	