



MAXIDURA - 124 Mo (SS-310)

Fully austenitic heat resistant stainless steel electrode

ALLOY BASIS

Fe, Cr, Ni

PROPERTIES

Fully austenitic, heat resistant deposit Heat resistant at working temperatures up to 1200-1400 °C. in oxidizing,

TECHNICAL DATA

UTS : 54-67 kgf/mm²

Elongation : 32-34%

TYPICAL APPLICATIONS

Welding of austenitic stainless, heat resistant Cr-Ni steels of the type 25 Cr / 20 Ni). Also suitable for welding of steels with high carbon content often used in the construction field. Furnace linings, furnace parts, burners, heat treatment pots and baskets.

PROCEDURE

Clean and de-grease the area to be welded. For heavy thickness prepare a 45° included angle Vee. Fit up should be accurate for long joints. Weld at regular intervals and use jigs and fixtures to avoid distortion. Use DCEP (DC+) on DC Power Source for good ripple and finish. Stringer bead technique with shortest possible arc length is recommended.

WELDING CURRENT

CURRENT	AC/DC(+)	
Size (mm)/Length	3.15x350	4.0x350
Current(amps)	90-120	120-160

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