



Typical Properties :

Undiluted Weld Metal

Tensile strength
Yield strength
Elongation
Hardness

Maximum Value up to:

70,000 psi (500 N/mm²)
49,000 psi (350 N/mm²)
20%
Rockwell B 88-90 Brinell 180
Vickers 189

Flux Color: Black

Microstructure: Consists of an iron-nickel austenite with finely distributed graphite.

Recommended Current: DC Reverse (+) or AC

Recommended Amperage Settings:

Diameter (mm)	1/8 (3.25)
Minimum Amperage	70
Maximum Amperage	110

Welding Position: Flat, Horizontal, Vertical Up, Overhead

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Electrodes	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition Min/lb (kg)	Amperage Setting
1/8 (3.25)	14" (350)	.76oz (21g)	21 (47)	24 (55)	90

Welding Techniques: Remove any surface contamination with the proper solvents. Adjust the welding machine to the lowest proper setting that yields good welding conditions.

Electrode Packaging & Dimensions

Diameter (mm)	1/8 (3.25)
Length (mm)	14" (350)
Electrodes/lb	15
Electrodes/kg	33

NINJA