RELIANT

Typical Properties:

Undiluted Weld Metal	**Maximum Value up to:**
Tensile strength	83,000 psi (600 N/mm²)
Yield strength	75,000 psi (540 N/mm²)
Elongation	25%
Impact Energy	90J: -4°F (-20°C)

Recommended Current: DC Straigh (-), Reverse (+) or AC

Recommended Amperage Settings:

Diameter (mm)	3/32 (2.5)	1/8 (3.25)
Minimum Amperage	50	70
Maximum Amperage	70	110

Welding Position: Flat, Vertical Up, Vertical Down, Horizontal, Overhead

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Electrodes	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition Min/lb (kg)	Amperage Setting
3/32 (2.5)	14" (350)	.30oz (8g)	53 (117)	36 (79)	60
1/8 (3.25)	14" (350)	.62oz (17g)	26 (57)	25 (55)	90

Welding Techniques: Hold a short to medium arc length, lean electrode 45° towards the direction of travel. Use either the stringer or weave technique.

Electrode Packaging & Dimensions:

Diameter (mm)	3/32 (2.5)	1/8 (3.25)
Length (mm)	14" (350)	14" (350)
Electrodes/lb	25	15
Electrodes/kg	55	33