



## Typical Properties:

### Undiluted Weld Metal

Tensile strength

Yield strength

Elongation

### Maximum Value up to:

34,000 psi (250 N/mm<sup>2</sup>)

20,000 psi (150 N/mm<sup>2</sup>)

18%

**Flux Color:** White

**Recommended Current:** DC Reverse (+)

**NOVA**

### Recommended Amperage Settings:

Diameter (mm)	3/32 (2.5)	1/8 (3.25)
Minimum Amperage	50	70
Maximum Amperage	80	120

**Welding Position:** Flat, Horizontal

### Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Electrodes	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition Min/lb (kg)	Amperage Setting	Recovery Rate
3/32 (2.5)	14" (350)	.14 oz (4.3g)	114 (251)	110 (242)	70	90%
1/8 (3.25)	14" (350)	.23oz (6.5g)	70 (153)	62 (136)	110	90%

**Welding Techniques:** Start by using upper portion of the amperage range. Feed the electrode quickly and move fast maintaining a very close arc gap.

### Electrode Packaging & Dimensions:

Diameter (mm)	3/32 (2.5)	1/8 (3.25)
Length (mm)	14" (350)	14" (350)
Electrodes/lb	49	33
Electrodes/kg	108	73