



Typical Properties :

Undiluted Weld Metal

Tensile Strength
Yield Strength
Elongation

Maximum Value up to:

71,000 PSI (490 N/mm²)
64,000 PSI (440 N/mm²)
27%

INDIGO

Recommended Torch Setting: Neutral Flame

Temperature Ranges:

Working Temperature	1595°F (878°C)
Melting Range	1583° - 1620°F (870° - 885°C)

Welding Position: Flat, Horizontal, Vertical Up, Overhead

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Rod	Rods per lb (kg) of Weldmetal
1/8 (3.25)	18" (450)	1.1 oz (31g)	15 (33)

Welding Techniques: Insure that parts to be joined are clear. Pre-heat general area to 700°F (400°C) and then specified area to 1200°F (650°C). Melt off flux and apply alloy.

Electrode Packaging & Dimensions:

Diameter (mm)	1/8 (3.25)
Length (mm)	18" (450)
Electrodes/lb	13
Electrodes/kg	29