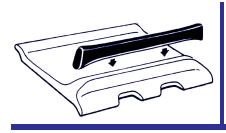


SHUBER E 690

DIFFICULT-TO-WELD STEELS



DESCRIPTION

ELECTRODE DESIGNED FOR JOINING NON-ALLOYED TO ALLOYED STEELS, "HARD-TO-WELD" HARDENABLE STEELS AND HOT WORKING STEELS. It is recommended for austenitic-to-ferritic joints particularly cladding or as buffer layer on various base metals. It has excellent corrosion resistance at normal temperatures and has outstanding oxidation resistance at elevated temperatures.

Especially suited for repairs on hot and cold forging dies, drawing and forming tools due to its workhardening properties and heat resistance.

SPECIAL FEATURES

- Economical for stress & crack resistance applications.
- Excellent heat and corrosion resistance.
- High work hardenability in service.

APPLICATION INSTRUCTIONS

Use AC or DC+(Reverse Polarity). Weld with lowest current possible and hold a short arc as possible. Deposit stringer beads and avoid excessive weaving to prevent slag inclusions. Use intermittent welding to avoid overheating and warpage.

TECHNICAL DATA

TENSILE STRENGTH: 67 kg/mm² (95,000 psi)

ELONGATION: 35 %

RECOMMENDED CURRENT:

	DIAMETER	AMPS
AC or DC +(Reverse Polarity)	2.4 mm (3/32")	40 - 70
	3.2 mm (1/8")	70 - 110
	4.0 mm (5/32")	110 - 140

Tip Colour: Blue