

Xuper 660NH

Manual Metal Arc Electrode With Double Coating For Joining Of Structural Steel

DESCRIPTION:

Special maintenance and repair welding electrode with advanced by pherical coating offering the benefits of a rutile and of a basic coating. The deposit is smooth and regular. Very stable arc with transfer in fine droplets with low spatters. Good penetration. Adapted to contact welding. Approved for applications between -40C and 350C

Its mechanical properties are higher than most of structural steels.

- Low heat input and low hydrogen electrode that minimizes harmful base metal transformations.
- Exceptional all-position weldability
- Crack-free welding deposits
- Quick freezing easy slag removal
- High energy arc concentration for good penetration even in M&R condition.

PROCEDURE FOR USE

Preparation: Clean the area to be welded. Adapt the size of the electrode and amperage to the size of the part.

Preheating : Depends on the steels Carbon Equivalent and ti workpiece size, thickness and the geometry. Castolin Eutectic recommends:

CE < 0.2 : preheating not essential.

CE 0.2 - 0.4: preheating 100-200°C

CE 0.4 - 0.8 : preheating 200-350°C

Note that 12-14% Mn steels should never be preheated and that the workpiece temperature during welding should be kept below 250°C.

Welding: Employ a near vertical electrode angle and maintain a short arc length. (Avoid too long arc which could result in weld porosity). When re-striking the arc, commence approximately 10-12 mm back from the previous weld crater and progress forward, thus ensuring complete coverage of the crater area. Deposit either as stringer beads or minimum weaving.

Clean each weld bead thoroughly, removing all slag residues prior to commencing subsequent deposits. Do not attempt to use electrodes if suspected of being damp or electrodes with damaged flux coatings. Welding parameters: Welding current: = (+) / ~

Welding positions

PA, PB, PC, PD, PE, PF, according to ISO 6947

TYPICAL APPLICATIONS:

For joining of non or low alloyed steel and high resistance fine grained steels. The typical application are: tack welding, in situ ,workshop or repair welding in machine construction and shipyards, for containers and pressure vessels.

TECHNICAL DATA:

- Tensile Strength: 655 N/mm² (95,000 psi)
- Yield Strength: 448 N/mm² (65,000 psi)
- **Current & Polarity: AC/DC (+)**

DIAMETER	AMPERAGE
2.5mm	70-90
3.2mm	100-130
4.0mm	130-170
5.0mm	200-235

Note: For optimum result use the lowest amperage practical