



PHILARK PH SS 10

Coated Electrode for joining SS to itself and with MS Steels exposed to high temperatures



General Description

A unique all position austenitic stainless steel welding alloy which is ideal for high oxidation resistance maintaining high strength at temperatures upto 1200 degrees Celsius.

It is also suitable for joining of stainless steels of unknown composition. It produces a smooth and even metal transfer with very low spatter.

Oxidation Resistance	■	■	■	■	■	■	■	■	■
Crack Resistance	■	■	■	■	■	■	■	■	■
Heat input	■	■	■	■	■	■	■	■	■

Mechanical Properties of Weld Metal

Tensile Strength : 63 - 68 kg/mm²
Elongation (L=5d) : 35 - 38 %

Typical Applications

- Furnace Parts
- Heat Exchangers
- Heat Treatment pots and baskets
- Tanks Valves
- Anchor Joints
- Reaction Vessels



Anchors

Welding Parameters

Current Type and Polarity : AC/DC(+)
Welding Positions: All Flat, Vertical, Overhead

Diameter [mm]	2.50	3.15	4.0
Length [mm]	350	350	350
Current [A]	50-75	60-110	90-130

PHILARK ALLOYS

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