



PHILARK PH SS 7

Coated Electrode for High Alloyed Special Steels Difficult to Weld



General Description

It is a special electrode for welding steels having limited weldability, such as manganese steels, hardenable steels and others. It is an AC/DC electrode giving a non-magnetic and work hardenable stainless steel deposit containing Cr-Ni- Mn-Mo. The tough weld metal is able to absorb high welding stresses which is very important for achieving crack-free welds..

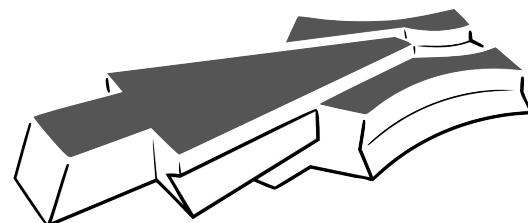
Mechanical Properties of Weld Metal

Tensile Strength : 58 - 64 kg/mm²
Elongation (L=5d) : 38 - 42 %
Hardness : 160 - 180 HB (as welded)
400 - 420 HB (cold worked)

Pressure									
Impact									
Abrasion									
Heat									
Corrosion/Cavitation									

Typical Applications

- Site machinery
- Drilling tools
- Rails, points
- Valve seats
- Earth moving equipments
- Stone working machines
- Coal machines
- Armoured cars
- Joining between X5 CrNiMo 18 10, X10 CrNiMoNb 18 10, HI-HIII, 17 Mn 4



Railways Rails & Crossovers

Welding Parameters

Current Type and Polarity : AC/DC(+)

Diameter [mm]	2.50	3.15	4.0	5.0
Length [mm]	350	350	350	450
Current [A]	85-110	120-150	150-180	160-190

PHILARK ALLOYS

REGD. OFFICE & WORKS: E 37, UPSIDC, MG ROAD, HAPUR, UP



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