

- ▲ Easy-to-Use Rutile Type, High Alloy Electrode.
- ▲ Outstanding Operator Appeal!
- ▲ WELDS ALL Steels!
- ▲ Ideal for Repair & Maintenance Jobs.
- ▲ Easy Arc Starting and Excellent Stability on Low O.C.V. Welding Machines.
- ▲ Not Recommended for Welding Cast Irons.

Classifications:

AS/NZS 1553.3	E312-17.
AWS/ASME-SFA A5.4:	E312-17.

Description and Applications:

WELDALL is a highly alloyed stainless steel electrode which deposits a strong and ductile duplex austenite-ferrite weld metal extremely resistant to cracking.

WELDALL has a host of features which make it suitable for the welding of all types of steels.

These include;

- ◆ Easy arc starting and excellent stability on low Open Circuit Voltage (O.C.V) welding machines such as the CIGWELD Easywelder EC.
- ◆ Rutile type flux coating gives smooth, stable running in all positions (except vertical down) especially on low current settings.
- ◆ High ferrite ($\approx 40\%$) austenitic stainless steel deposit gives excellent resistance to hot cracking, even when diluted with carbon, austenitic and high alloy steels.
- ◆ Weld deposit gives excellent resistance to corrosion and oxidation.

WELDALL is recommended for the repair and maintenance of all steels, particularly those of unknown composition. It is suitable for;

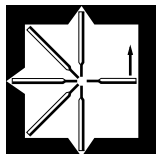
- ◆ Joining dissimilar steels, such as stainless steel to carbon steel.
- ◆ Repairing die or tool steels.
- ◆ Use as a protective overlay against corrosion.
- ◆ Use as an intermediate or buffer layer prior to hard surfacing.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

0.2% Proof Stress	630 MPa
Tensile Strength	780 MPa
Elongation	25%
CVN Impact Values	30 J av @ +20°C.

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.11%	Mn: 0.60%	Si: 0.88%
Cr: 27.0%	Ni: 9.10%	S: 0.011%
P: 0.020%		



All positional - except vertical down

Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ polarity.

Electrode Size mm	Electrode Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Easyweld Handipaks	Part No
2.5	300	57	40-80	2.5kg	15kg - 6 x 2.5kg		611702
						20 rod	322101
3.2	350	30	75-110	2.5kg	15kg - 6 x 2.5kg		611703
						15 rod	322102
4.0	350	20	110-150	2.5kg	15kg - 6 x 2.5kg		611704

Easyweld Blister Pack:

10 x 2.5mm/5 x 3.2mm rod Weldall Blister Pack	322216
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