

SUPERMATIC

A specially designed 'Lo Temp' electrode for all position contact welding with minimum heat input, very low distortion and warpage for use on low carbon steels with outstanding weld bead appearance.

Applications:

For fabrication of thin gauge sheets, tanks, pipelines, containers and other assemblies where distortion and heat stresses are to be minimized. Also designed for super conditioning of sugar mill roller journal shafts etc.

Procedure:

Machine/grind to remove fatigued metal. Hold electrode at right-angle in the direction to travel. Do not weave during contact welding. Avoid arc gap where distortion and positional welding are important. Slag is self-releasing.

Technical Data:

Size	: 2.0	2.5	3.15	4.0	5.0
Recommended Welding Current (Amp)	:35-60	60-90	80-120	110-170	140-200
Ultimate Tensile Strength	: 50-67 kgf / mm ²				
Elongation	: 22% (Min.)				
CVN Impact Strength at +20 °C	: 47 J (Min.)				
Tip Colour	: Yellow				

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