

# ASTRÄ ZF

## Super resistance to sulphuric acid corrosion

Asträ ZF is a high performance electrode with excellent corrosion resistance to acids than the standard AISI 316L or 317L types where the alloy content is lower. A rutile based electrode, Asträ ZF is characterized by smooth running and a selfpeeling slag.

**ALLOY BASE:** Fe, Cr, Ni, Cu, Mo

## SPECIAL FEATURES:

- Nil-ferrite deposit
- Stunning resistance to sulphuric, phosphoric, acetic acids
- Smooth arc, a ripple free bead and a slag that removes itself

## APPLICATIONS

The electrode is designed for welding stainless steels of

corresponding composition viz. Carpenter 20, SS 2562, Avesta 254 SLX UHB 904L, Sandvik 2RK65, 2RN65, etc. The weld deposit is resistant to sulphuric, phosphoric, acetic, oxalic, formic and other acids like fatty acids. The electrode can be successfully applied in pipeline and storage applications handling the above chemicals.

## PROPERTIES

UTS	: 56-58 kg/mm <sup>2</sup>
Elongation (l=4d)	: 33-35%
Ferrite	: 0

## CURRENT RANGE : (DC+, AC 65

Size (mm)	Length (mm)	Current Range (Amp)
2.50	350	90-110
3.15	350	120-140
4.00	350	150-185
5.00	350	170-250