

TERROWELD DS4

Welding stainless steels to any other steel and overlays

Terroweld DS4 is a smooth running rapid flowing electrode giving a deposit that is strong and ductile for very good resistance to impact. The weld metal is also suitable for stainless overlays, 'butter layers' as they are known, on carbon steels prior to joining with other stainless steels. It is also used for joining stainless steels to any other steel.

ALLOY BASE: Fe, Cr, Ni, Mn, Mo

SPECIAL FEATURES

- Ease of operation.
- Easy slag peel off revealing shining bead.
- Thick bead facilitating smooth surfacing.

APPLICATIONS

Welding stainless steels to carbon steels, mild Steel, low alloy steels, cast steels and austenitic manganese steels. This can be used for high temperature applications for temperatures upto 1200°C like Kiln Anchor Joining, Immersion tube welding and all other high temperature applications. This product is widely used in all Cement Industries for these applications.

PROPERTIES

UTS : 55-65 kg/mm²

Elongation : 28-34%

CURRENT RANGE : (AC 70, DC±)

Size (mm)	Length (mm)	Current Range (Amp)
2.50	350	40-80
3.15	350	70-100
4.00	350	80-130
5.00	350	110-140