

ECO-680CGS

Special Electrode

Fine Carbon grain structures with superior cracks resistively universal stainless steels welding electrodes

Basis OF Alloys : C, Mn, Cr, Ni

Application & Descriptions : ECO- 680CGS controlled grain structure and control ferrite low heat input austenitic-ferritic stainless steel welding electrode. Electrode is formulated in such a way that it allows welding steels of widely varied composition including “DIFFICULT-TO-WELD” steels,.

For joining difficult-to-weld steel and dissimilar steels such as dies, tool and spring steels and joining steel to unknown composition, also used as cushion layer on difficult steels to weld steel before depositing final hard facing layer.

RE-DRY CONDITION : Re-Dry the electrode at 350°C for 1 hour,

ALL WELD MECHENICAL PROPERIES (TYPICAL):

UTS	Elongation	HARDNESS
780 N/mm ²	25%	AS WELDED 210 BHN

DIEMENSION, CURRENT CONDITION & PACKING DATA:

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/ AC) Amps	weight of packet (Kgs)	Weight of Case
2.50x350mm		50-80	2	20
3.20x350	1	70-110	2	20
4.00x350	5/	100-130	2	20
5.00X350	3/	130-160	2	20