

SUNALLOY 621

Fully austenitic heat resistant stainless steel electrode



DESCRIPTION

Fully austenitic, heat resistant deposit. Heat resistant at working temperatures up to 1200 °C in oxidizing sulphur free atmosphere.

ALLOY BASIS

Fe, Cr, Ni

APPLICATIONS

Welding of austenitic, stainless, heat resistant Cr-Ni steels of the type 25 Cr / 20 Ni (NCT, AISI 310, Ugine NS 30, Avesta 254 E, Sandvik 15 RE 10). Also suitable for welding of steels with high carbon content often used in the building field. Furnace linings, furnace parts, burners, heat treatment pots and baskets

PROCEDURE

Clean and de-grease the area to be welded. For heavy thickness prepare a 60° included angle Vee. Fit up should be accurate for long joints. Then weld at regular intervals and use jigs and fixtures to avoid distortion. Use DCRP (DC+) on DC power source for good ripple and finish. Stringer bead technique with shortest possible arc length is recommended.

TECHNICAL DATA

UTS : 55 - 65 kgf/mm²
Elongation : 30 - 35%

WELDING PARAMETERS

Size (diameter)/length (mm)	: 2.50 x 350	3.15 x 350	4.00 x 350	5.00 x 350
Current (amps)	: 50 - 75	70 - 100	100 - 135	100 - 160
Current	: AC/DC (+)			