

GOLD 627 -E FOR ALLOY AND PROBLEM STEEL

Description and Applications:

Multipurpose high alloy electrode for repair welding on alloy and high-alloy-steels, tool-steels, stainless steels and dissimilar assemblies.

high mechanical properties high corrosion resistance, combined with an **excellent welding performance** make this electrode ideal for repair of unknown types of stainless steel, mild steel to stainless, galvanized steel Stainless steel tanks and pipes, heat exchangers, chassis, springs ,plates, drill bits, moulds, dies, press tools, chains, crane booms, shafts, tools, a. rotors....

Weldmetal: Cr,Ni,Mo,Fe



Repair broken gears



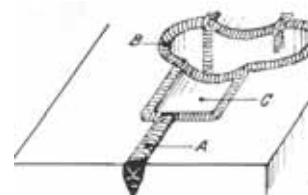
Rebuild worn shafts



Weld dissimilar steels



Repair cracks in chassis



Repair tools and dies

Mechanical properties
Up to :

Rm (MPa) 800	Rp 0,2 (MPa) 550	A5 (%) 25
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Packaging
Data

Sizes	2.0x300	2.5x300	3.2x350	4.0x350
Kgs/Packets	3,5	4	4,5	4,5
Packets/carton	4	4	4	4
Kgs/carton	14	16	18	18

Welding instructions

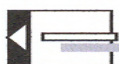
Current (A)	50	80	110	140
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1G/PA



2F/PB



2G/PC



3G/PF



4G/PE



= + ~50V

FEATURES

Highest crack resistance. Able to weld over 1000 different steels and steels of unknown analysis.

Low amperage coating reducing heat input, preventing cracking and distortion.

Ideal For use as buffer layer prior to hard facing (Hardness 240-280 HV 30)

Welds successfully even on rusty contaminated surfaces. weld deposit can be machined and will work harden in service. Can be used on AC or DC Machines with excellent weld ability.