

GOLD 655-E FOR DUPLEX/STAINLESS STEEL

Description and Applications:

Special electrode to welding of stainless and steel parts subject to high corrosion. Highest resistance to pitting and chloride containing solutions. Weld metal has high strength
 Used for welding of stainless steels in off shore plants, food-, brewing-, pharmaceutical -, chemical -, petrochemical - industries, in water treatment, for tanks, pumps, mixers turbine blades etc.
 For joining and overlaying of parts requiring high strength and high resistance to pitting and stress corrosion
 -No spatter, no overheating, high acid and corrosion resistance
 -Fully austenitic-ferrite deposit (duplex)

For welding UNS S 31803, S 32304, S 32900, Alloy 35 N, 329 N
 URANUS 45 N MAT. NO 1.4462, 1.4362 AND SIMILAR



Mechanical properties

Up to:

Packaging
Data

Rm (MPa) ≥680	Rp0,2 (MPa) ≥540	A5 (%) ≥22
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Sizes	2.5x300	3.2x350	4.0x450
Kgs/ Packet	4	4,5	5,5
Packets/ carton	4	4	4
Kgs/ carton	16	18	22

HINTS:

Current (A) DC+, AC OCV 70	70	100	130
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Welding positions



Recommendations for stainless steel welding:

Clean weld area. Bevel heavy sections 60°-90° Vee

Select lowest possible amperage

Weld with stringer beads and use short arc. Remove slag between passes

Use only stainless steel brushes to clean welds

Use staggered weld sequence to balance heat input. For maximum corrosion resistance remove discoloration by brushing or pickling