

Stainless Steel Electrodes

Alloy: WW Super blue

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Weld Process: Shielded Manual Metal Arc

Deposited Chemical Composition % (Typical)

C = 0.10      Cr = 29.0      Si = 0.90  
Ni = 10.0      Mn = 0.80

Deposited All Weld Metal Properties %  
(Typical) As-Welded

Yield Strength      71,000psi  
Tensile Strength      100,000psi

Deposited Charpy-V-Notch Impact Properties %

20 ft. lbs. (tested at 70°F)

Recommended Welding Parameters

Current AC or DCRP

<u>Diameter</u>	<u>Amperes</u>
3/32	60 - 90
1/8	80 - 120
5/32	110 - 160
3/16	140 - 220

Application

Super blue is noted for good weldability, easy slag removal, high tensile and yield strength and elongation. Super blue is suitable for welding high strength alloyed structured tool and heat treatable steels, also for welding of dissimilar steel combinations. Preheating to 400°F is recommended.