DURAMAX®
Inspiring the future generations of welders

Product Data Sheet

DURAMAX SUPERBLUE --- BLUE FLUX COATED ELECTRODE

Product: DMSUPERBLUE **Classification: SUPERBLUE ELECTRODE**

Typical Application

Due to exceptional strength and crack resistance, it is ideal for repairing tools, dies, spring steel and any dissimilar metal combinations, except for the aluminum and copper alloys. It is also recommended for repairing worn parts and as an underlay for hardfacing. The ultimate electrode for welding all types of steels, without any danger of cracking or breakage. Special "FERRITE BALANCED" Chemistry also serves as a "STUD PULL" electrode

Characteristics on Usage

1)	An engineered deposit chemistry that has the perfect ratio of metallics to offer crack resistance far superior to any other brand.
2)	Special flux formulation eliminates slag interference in horizontal fillets.
3)	Slag is designed to turn to powder making this electrode ideal for "STUD PULL" applications.
4)	Special specification exceeding chemistry for extreme crack resistance.

Typical All Weld Chemical Composition (%)

C	Mn	Si	S	P	Cr	Ni	Cu	Mo	Fe
0.10	0.80	1.00	0.01	0.02	29.0	9.0	0.06	0.70	bal

Typical Mechanical Properties of Undiluted Weld Metal

Tensile Strength as welded:	880 MPa max	Elongation:	32%, 36% 17 coatings
Work Hardened:	1280 MPa max	Reduction of area:	25%
Yield Strength:	630 MPa max	Impact Energy:	50 (J): 68 Deg F (20 Deg C)
Hardness:	Brinell 225		

Sizes available and recommended currents (DC +) or (AC)

Dia. (mm)	Amperage	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min / lb (kg)	Amperage Settings	Recovery Rate
5/64 (2.0mm)	30 ~ 55	.14 oz (4g)	114 (251)	47 (103)	40	100%
3/32 (2.5mm)	35 ~ 70	.38 oz (11g)	40 (88)	37 (82)	65	100%
1/8 (3.2mm)	60 ~ 110	.64 oz (18g)	25 (55)	26 (58)	100	100%
5/32 (4.0mm)	75 ~ 140	1 oz (28g)	16 (36)	21 (46)	130	100%

Welding Techniques

The area in which the weld is to be made should be free of rust, grease, paint and other materials which cause weld contamination. A 90º vee joint should be used when joining heavy sections. Maintain a short arc length and use stringer beads.
POLARITY: DCEP or AC. DCEP = DC, Electrode Positive (reverse polarity) has the most weld penetration. AC: medium weld penetration (can be more spatter). USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS. WELDING POSITIONS: Flat, Horizontal, Vertical-up and Overhead positions

If additional information is needed please visit our website: www.duramaxwelding.com

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