

CIGWELD

AN ESAB BRAND

STICK

WELDALL

PRODUCT DATA SHEET



HIGHLY ALLOYED STAINLESS STEEL ELECTRODE

45
OCV

AC
DC+

STAINLESS STEEL AND SPECIAL ELECTRODES

WELDALL

- Easy-to-Use Rutile Type, High Alloy Electrode.
- Outstanding Operator Appeal!
- WELDS ALL Steels!
- Ideal for Repair & Maintenance Jobs.
- Easy Arc Starting and Excellent Stability on Low O.C.V. Welding Machines.
- Not Recommended for Welding Cast Irons.
- Packed in Resealable Plastic Tubes.

CLASSIFICATIONS:

ISO AS/NZS 4854:	B ES312-17
AWS/ASME-SFA A5.4:	E312-17

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

0.2% Proof Stress	630 MPa
Tensile Strength	780 MPa
Elongation	25%
CVN Impact Values	30 J av @ +20°C

TYPICAL ALL WELD METAL ANALYSIS:

C:	0.11%
Cr:	28.4%
Mn:	0.60%
Ni:	9.10%
Si:	0.88%
S:	0.011%
P:	0.020%

DESCRIPTION AND APPLICATIONS:

WELDALL is a highly alloyed stainless steel electrode which deposits a strong and ductile duplex austenite-ferrite weld metal extremely resistant to cracking.

WELDALL has a host of features which make it suitable for the welding of all types of steels. These include;

- Easy arc starting and excellent stability on low Open Circuit Voltage (O.C.V) welding machines such as the CIGWELD Easywelder EC.
- Rutile type flux coating gives smooth, stable running in all positions (except vertical down) especially on low current settings.
- High ferrite ($\approx 40\%$) austenitic stainless steel deposit gives excellent resistance to hot cracking, even when diluted with carbon, austenitic and high alloy steels.
- Weld deposit gives excellent resistance to corrosion and oxidation.

WELDALL is recommended for the repair and maintenance of all steels, particularly those of unknown composition. It is suitable for;

- Joining dissimilar steels, such as stainless steel to carbon steel.
- Repairing die or tool steels.
- Use as a protective overlay against corrosion.
- Use as an intermediate or buffer layer prior to hard surfacing.

PACKAGING & OPERATING DATA:

AC (minimum 45 O.C.V.), DC+ polarity.

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	APPROX NO. RODS/KG	CURRENT RANGE (AMPS)	PACK SIZE	CARTON	PART NO.
2.5	300	49	50-85	1.6kg	9.6kg - 6 x 1.6kg	611702N
3.2	350	27	60-125	1.8kg	10.8kg - 6 x 1.8kg	611703N
4.0	350	16	80-175	4.4kg	13.2kg - 3 x 4.4kg	611704N

WELDING POSITIONS:

All positional - except vertical down.

