



Applications

Contact type special electrode for joining and surfacing of 25/20 Cr-Ni steels with high resistance to heat & scaling upto 1200°C. Chief application area of these electrodes are furnace parts, pipe work fittings, 310 type stainless steel.

Technical data

Current -: AC/DC (+)
Tensile Strength -: > 590 N/mm²
Elongation -: > 30%

SPECTRUM 68H

Features and benefits

- * High heat and scale resistant deposit upto 1200°C.
- * Smooth flow, easy slag removal.
- * For welding similar grade steels and for cladding.
- * Finely rippled bead surface.
- * Weldable in all positions.

Applications

Special purpose, rutile coated austenitic stainless steel electrode designed for sugar factories maintenance applications. Particularly suited for multi-purpose joining applications involving AISI301, 302, 304, 308 stainless steels.

Technical data

Current -: AC/DC (+)
Tensile Strength > 550 N/mm²
Elongation - :> 35%

SPECTRUM 6804

Features and benefits

- * All position contact type electrode.
- * Weld metal has excellent corrosion resistance.
- * High arc stability and low spatter losses.
- * Weld beads are smooth, uniform and of excellent appearance.

Applications

Contact type electrode for the joining and repair of parts subjected to corrosion in 308 type of stainless steels.

Technical data

Current -: AC/DC (+)
Tensile Strength -: > 590 N/mm²
Elongation - :> 35%

SPECTRUM 6808

Features and benefits

- * For part deposition, joining and cladding.
- * All position contact type electrode.
- * Good corrosion resistance in 308 type of SS.
- * Easy slag detachability.

Applications

Contact type high alloy electrode for joining and repair of parts in the following types of stainless steel : 25/20 Cr-Ni steels and 310 type.

Technical data

Current -: AC/DC (+)
Tensile Strength -: > 570 N/mm²
Elongation - :> 30%

SPECTRUM 6810

Features and benefits

- * Fully austenitic high alloyed Cr-Ni electrode.
- * Suitable for high heat applications.
- * Suitable for all positions in situ welding.
- * Easy slag removal.
- * Contact type electrode.

Applications

Contact type austenitic stainless steel electrode for joining and anti-corrosion coating on stabilised chemically resistant 316 type stainless steel.

Technical data

Current -: AC/DC(+)
Tensile Strength -: > 585 N/mm²
Elongation - : > 35%

SPECTRUM 6816

Features and benefits

- * High quality, all position electrode.
- * Suitable for all positions in situ welding.
- * Good corrosion resistance on similar grades of stainless steels.
- * Good quality weld beads with easy slag removal.



Applications

Special alloy electrode for joining and anti-corrosion coating on unstabilised chemical resistant steels of range 302, 304, 305, 202, 308.

Technical data

Current -: AC/DC (+)
Tensile Strength -: > 585 N/mm²
Elongation -: > 35%

**SPECTRUM
6820**

Features and benefits

- * Excellent welding characteristics.
- * All position contact type electrode.
- * Easy striking & restriking.
- * Finely rippled bead without undercuts.
- * Best suited for acid resisting Cr-Ni steels.

Applications

Extra low carbon stainless steel electrode for joining and surfacing on stabilised chemically resistant steels 202, 302, 304, 304L, 305, 308, 308L

Technical data

Current -: AC/DC (+)
Tensile Strength -: > 590 N/mm²
Elongation -: > 35%

**SPECTRUM
6820 LC**

Features and benefits

- * Low carbon electrode for stainless and acid resisting Cr-Ni steels.
- * All position contact type electrode.
- * Heat resistance upto 700°C.
- * Stable arc gives clean, uniform beads without under cutting.
- * Very easy slag removal.
- * Instantaneous strike/restrike.

Applications

Special alloy electrode for joining and anti-corrosion coating on chemically resistant Cr-Ni-Mo steels of range 316 type.

Technical data

Current -: AC/DC (+)
Tensile Strength -: > 590 N/mm²
Elongation -: > 35%

**SPECTRUM
6820 Mo**

Features and benefits

- * A good all round stainless steel type electrode.
- * Excellent corrosion resistance to acids.
- * Excellent weldability in contact, minimum spatters.
- * Deposits uniform beads with excellent finish.
- * Exceptional welding in all positions.

Applications

Extra low carbon electrode for joining and repair of parts in the stabilised and unstabilised chemically resistant Cr-Ni-Mo steels, 316, 316L, stainless steels.

Technical data

Current -: AC/DC (+)
Tensile Strength -: > 585 N/mm²
Elongation -: > 35%

**SPECTRUM
6820 MoLC**

Features and benefits

- * Heat resistant up to 700°C in conjunction with low carbon parent metal.
- * Excellent resistance to corrosion.
- * Clean, spatter free deposits.
- * All position contact type electrode.
- * Easy to strike/restrike.
- * Stable intense arc.

Applications

Special unstabilised, alloy electrode for joining and surfacing of low alloy corrosion and heat resistant Cr-Ni steels and 309 type of stainless steels.

Technical data

Current -: AC/DC (+)
Tensile Strength -: > 620 N/mm²
Elongation -: > 30%

**SPECTRUM
6824**

Features and benefits

- * Widely used for welding carbon steels to stainless steels.
- * Good quality welds.
- * Very good heat and corrosion resistance.
- * All position contact type electrode.
- * Low spatter with auto slag release.



Applications

Special high alloy manual electrode for joining and repair of corrosion and heat resistant stainless steels. Applications include parts made of 309, 309L, type of stainless steels.

Technical data

Current-: AC/DC (+)
Tensile Strength -: > 620 N/mm²
Elongation -: > 30%

SPECTRUM 6824 LC

Features and benefits

- * Excellent corrosion and heat resistance upto 1000°C.
- * Special high alloy Cr-Ni electrode.
- * Steady arc, low spatters and very easy slag removal.
- * Contact type all position electrode.

Applications

Specially formulated Mo bearing deposit electrode for joining and anti-heat & anti-corrosion coating on 309, 309Mo, 316 and 318 types of stainless steels. Also joins M.S. to Cr-Ni-Mo steels.

Technical data

Current-: AC/DC(+)
Tensile Strength -: > 620 N/mm²
Elongation -: > 35%

SPECTRUM 6824 Mo

Features and benefits

- * Special electrode for high heat (upto 1000°C) and corrosion resistance in Cr-Ni-Mo steels.
- * Very good crack resistivity when joining and cladding different materials.
- * Excellent characteristics like steady arc and homogeneous bead structure without porosity.

Applications

Extra low carbon, Mo bearing deposit. Specially formulated electrode for joining and anti-heat & anti-corrosion coating on 309, 309L, 309Mo, 309LMo, 316, 316L, 316Ti and 318 types of stainless steels. Also joins M.S. to Cr-Ni-Mo steels.

Technical data

Current -: AC/DC(+)
Tensile Strength -: > 620 N/mm²
Elongation -: > 35%

SPECTRUM 6824 MoLC

Features and benefits

- * Special electrode for high heat (upto 1000°C) and corrosion resistance in Cr-Ni-Mo steels.
- * High crack resistivity when joining and cladding different steels.
- * Characterised by steady arc, homogeneous bead structure and no porosity.

Applications

Special stabilised austenitic manual electrode for joining and repair of the parts of stainless steels like 316, 316L, 316Ti and 318.

Technical data

Current-:AC/DC (+)
Tensile Strength -: > 620 N/mm²
Elongation -: > 35%

SPECTRUM 6824 MoNb

Features and benefits

- * Heavy coated stabilised special electrode.
- * High crack resistivity.
- * Weldable in all positions.
- * Excellent heat and corrosion resistance.
- * Homogeneous seam structure, no porosity and minimum spatters.
- * Very easy slag removal.

Applications

Special stabilised austenitic manual electrode for joining and surfacing on stabilised and unstabilised heat and corrosion resistant Cr-Ni steels. Applications include parts made of 309 types and alloy steels.

Technical data

Current -: AC/DC(+)
Tensile Strength -: > 620 N/mm²
Elongation -: > 30%

SPECTRUM 6824 Nb

Features and benefits

- * Special coating for stabilised corrosion and heat resistant stainless steel.
- * Weld beads are smoothly rippled and free of pores.
- * All position Touch Welding¹ electrode.
- * Steady arc, low spatter and very easy slag removal.

**Applications**

Extra low carbon 19/13 Cr-Ni-Mo stainless steel electrode for joining and repair of parts subject to intercrystalline corrosion, stress corrosion cracking, hot cracking and chemical corrosion. Applications include guide vanes, hydel turbines, impellers.

Technical data

Current -: AC/DC (+)
Tensile Strength -: > 585 N/mm²
Elongation -: > 35%

**SPECTRUM
6817LC****Features and benefits**

- * Excellent corrosion resistance against sulphuric acid, sulphurous acids and phosphoric acids.
- * Controlled ferrite content (4 to 5%) to resist inter-crystalline corrosion, stress corrosion cracking, hot cracking and chemical corrosion.
- * High creep strength at elevated temperature.
- * Good crack resistivity under high restraint joints.

Applications

Extra low carbon stainless steel manual electrode suitable for 316L, 316 and 18/8 type of steels. Applications are pertaining to these steel parts and for Urea service.

Technical data

Current -: AC/DC (+)
Tensile Strength -: > 580 N/mm²
Elongation -: > 35%

**SPECTRUM
68 MoLCLF****Features and benefits**

- * Low ferrite content (<2%) for Urea applications.
- * Superior resistance to intergranular corrosion.
- * Soft stable arc with controlled spatters.
- * Smooth, finely rippled, shining beads.
- * All position contact type electrode with easy slag detachability.

Applications

Contact type specially formulated heavy coated electrode for the joining and repair of parts types of stainless steels like 321, 347, 302, 304.

Technical data

Current -: AC/DC (+)
Tensile Strength -: > 585 N/mm²
Elongation -: > 30%

**SPECTRUM
68****Features and benefits**

- * For applications subject to carbide precipitation.
- * Contact type electrode.
- * Stable arc, Low spatter.
- * Clean, finely rippled seam surface without undercutting.
- * Resists intercrystalline corrosion upto 400°C.

Applications

Heavy coated Austenitic Stainless Steel Electrode for High Tensile Steels, Ferritic Steels, Mn Steels. Application include shafts, gear, heavy equipment

Technical data

Current -: AC/DC (+)
Tensile Strength -: > 785 N/mm²
Elongation -: > 30%

**SPECTRUM
685 AV****Features and benefits**

- * Contact type electrode
- * Easy slag removal
- * Stable arc, Low spatter.
- * Extremely crack resistant
- * Special high alloy Cr-Ni electrode

Applications

Special austenitic electrode for the joining and surfacing of parts on all types of steels - alloy steels, cast steels, Mn / Tool / Die / heat treatable steels. Applications include boiler tubes, Mn steel liners, dies and mould manufacture.

Technical data

Current -: AC/DC (+)
Tensile Strength -: > 780 N/mm²
Hardness -: 20 RC
Work hardens to 38 RC

**SPECTRUM
653****Features and benefits**

- * Mo content with high Cr & Ni gives work hardening properties upto 38 RC.
- * All position contact type electrode.
- * Steady arc with good slag detachability.
- * Scale resistance upto 750°C.