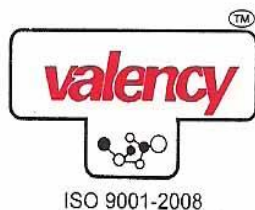


Low Heat Input Consumables for Joining & Fabrication of Stainless Steels

'Valency' manufactures all types of AWS coded austenitic & Ferritic range of Stainless Steel Electrodes suitable for applications requiring superior resistance to High Heat and Corrosion ,which rare widely recognized for superb welding characteristics viz. very low spatter , smooth arcing and excellent slag detachability.'



PRODUCT CATALOGUE FOR Electrodes for Heat & Corrosion resistance



C . ELECTRODES FOR HEAT & CORROSION RESISTANCE							
Product	Description	Applications	Typical Properties	Size and Current			
NICONEL 2424 [AC/DC+]	HIGH RECOVERY NICKEL ALLOY ELECTRODE, EXCELLENT RESISTANCE TO CORROSION, OXIDATION & THERMAL SHOCK AT HIGH TEMPERATURE .ALSO SUITABLE FOR CRYOGENIC RANGE	Joining & overlaying of Nickel & Nickel Chrome alloys, HK alloys, furnace parts, dissimilar parts, cryogenic & high temperature equipments & for Inconel type of alloys.	U.T.S. 630 N/mm ²	Size (mm) Amps	2.50 55-90	3.15 75-120	4.0 115-180
NICONEL 2525 [AC/DC+]	HIGH RECOVERY NICKEL ALLOY ELECTRODE, EXCELLENT RESISTANCE TO CORROSION, OXIDATION & THERMAL SHOCK AT HIGH TEMPERATURE .ALSO SUITABLE FOR CRYOGENIC RANGE	Joining & overlaying of Nickel & Nickel Chrome alloys, HK alloys, furnace parts, dissimilar parts, cryogenic & high temperature equipments & for Inconel type of alloys.	U.T.S. 630 N/mm ²	Size (mm) Amps	2.50 55-90	3.15 75-120	4.0 115-180
HK 3040 [AC/DC+]	SPECIALLY DESIGNED HIGH CARBON, CROMIIM & NICKEL BEARING ALLOY WITH GOOD CREEP RUPTURE PROPERTIES UPTO 1150°C	For Welding HK 30, HK 40 alloys, refrpmer tubes, AISI 309 & 310 type s.s, heat exchangers, furnace parts, heating element, heat treatment boxes, kiln cooler plates, reaction vessels etc	U.T.S. 600 N/mm ² , Elongation 35%	Size (mm) Amps	3.15 75-120	4.0 130-165	
NICARB-1150 [AC/DC+]	HIGH CARBON, CHROMIUM & NICKEL BEARING ALLOY, FOR WITH-STANDING HIGH TEMP. UPTO 1150 oC. HIGH CREEP RUPTURE PROLONGED LIFE AT ELEVATED TEMPERATURE	Welding & repairing of heat resistant castings for use in oxidizing & reducing atmosphere at high temp. in fertilizer, oil refinery & petrochemical industries.	U.T.S. 600-620 N/mm ² . Total Cr+Ni content above 50%	Size (mm) Amps	2.50 55-90	3.15 75-120	4.0 115-180

Product	Description	Applications	Typical Properties	Size and Current			
VALMET 2290 [AC/DC+]	HIGH RECOVERY (150%), NICKEL, CR, MO, CO BASED ALLOY. GIVES EXCELLENT THERMAL SHOCK RESISTANCE WITH SUPERIOR RUPTURE STRENGTH & CORROSION RESISTANCE IN OXIDIZING ACIDS AND CHLORINE. ALSO RESISTANT TO DEFORMATION AT HIGH TEMPERATURE UPTO 1100°C UNDER STATIC AND CYCLIC LOAD.	Joining and overlaying of Alloy 600, 617, 625 & 825	U.T.S. 880 N/mm ²	Size (mm) Amps	2.50 70-90	3.15 100-130	4.0 110-150
VALMET 2293 LN [AC/DC+]	NITROGEN BEARING 22Cr/ 9 Ni/3 Mo WITH EXTRA LOW CARBON IDEAL FOR WELDING DUPLEX STAINLESS STEELS. ALSO GIVES EXCELLENT CORROSION RESISTANCE IN MARINE ENVIRONMENTS	Low & Medium Carbon Steels, Heavy Sections, gears, sprockets etc.	U.T.S. 730 N/mm ² , Elongation 25%	Size (mm) Amps	2.50 60-80	3.15 80-110	4.0 110-140
VALMET 068 [AC/DC+]	FULLY AUSTENITIC NI/CR ALLOY SUITABLE FOR JOINING AND BUILD UP ON FERROUS ALLOYS, NICKEL AND NICKEL ALLOYS, COPPER AND COPPER ALLOYS CONFORMING TO AWS : 5.11 NiCrFe3 (Modified).	Hot rolling Guides, Tools and Dies, Reaction Vessels etc.	U.T.S. 625 N/mm ² , Elongation 35%	Size (mm) Amps	2.50 40-65	3.15 70-100	4.0 100-130