

TM
CINOX 270

An Non-synthetic, non-magnetic, high manganese stainless electrode for joining and buffer layers. electrode.

<i>Diameter</i>	<i>Amperage</i>
2.5mm/300mm	70 - 90
3.2mm/350mm	90 - 120
4.0mm/350mm	120 - 150

CHARACTERISTICS AND TYPICAL APPLICATIONS

CINOX 270 is an AC weldable electrode with an alloyed core, suitable for welding difficultly weldable steels of carbon content >0.7% which are at risk of cracking and for joint welding and surfacing on heat resistant stainless steels and casting. Suitable for joint welding of austenitic to ferritic steels which are exposed to service temperatures up to 300°C. Furthermore, CINOX 270 can be used for welding equalizing buffer layers prior to hardfacing and for repair welding of manganese steels, stainless steels, heat resistant weld metal, non-scaling up to 850°C and resistant to sulphurous waste gases at temperatures up to 500°C.

The weld metal alloy is case hardening and non-magnetic.

APPLICATION

For reclaiming and joining 14% manganese steels, as well as non-alloy and alloy structural and heat treatable steels.

WELDING TECHNIQUES

Never preheat manganese steels due to crack sensitivity. Always use minimal amperage.

TYPICAL MECHANICAL PROPERTIES

<i>Undiluted Weld Metal</i>	Maximum Value up to:
<i>Tensile strength</i>	101,000 psi (690 N/mm ²)
<i>Yeild strength</i>	76,000 psi (510 N/mm ²)
<i>Elongation</i>	40%
<i>Hardness</i>	Brinell 200, Rockwell C25
<i>Work Hardness</i>	Brinell 200, Rockwell C48
<i>Recommended Current</i>	DC reverse polarity (Electrode +) or AC
<i>Welding positions</i>	PA, PB, PC, PD, PE, PG