

Hardfacing and Wear Resistant SMAW Electrode

Welding Notes (SMAW Electrodes)

1. During welding, the arc starting point should be 1~2 cm behind the welding start point. Once the arc starts, pull it back to the welding start point to begin welding to avoid the occurrence of blow hole. This is known as the forehand & backhand arc starting technique.
2. Use short arc technique to prevent permeation of N₂ and O₂ into the arc creating blow hole and alloy elements burning loss.
3. If weaving is needed, the weaving width should not exceed 3 times the core wire diameter.
4. Consult the individual product notes for baking and cleaning requirement.