



APPLICATION Root Pass Protection Paste

The Special Paste is used for root protection when welding stainless or high Cr Ni steels when backing gas shielding (Argon purge) for root pass is not possible.

The parts to be welded have to be cleaned 20mm on each side of the root and coated with Special Paste. After coating, set up for welding has to be done within one hour.

The Special Paste cannot be used instead of shielding gas, but only when it is not possible to use backing gas on the root side. The application of Special Paste reduces the burn out of chrome and other elements. After welding there remains a shiny slag on the root side similar to SMAW slag which should be removed by chipping, brushing or grinding (as with MMA). For optimum corrosion resistance the root side should be pickled and passivated.

The Special Paste may be thinned by up to 20% with distilled water, however, if thinned it cannot be stored for more than 8 hours, even in a closed container.

Original Special Paste has a shelf life of approximately one year, when stored in a closed container at a room temperature of ~20°C.

The Special Paste contains the following main ingredients:

CaO, Al₂O₃, Fe, Cr, SiO₂, TiO₂, MgO, CO₂, + Alkaline Silicate