

Applications

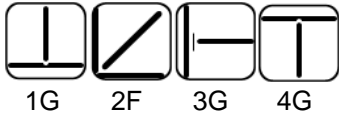
Suitable for welding 2.25% Cr, 1% Mo steels. Low alloy steel boiler and pipelines operation Repair of high tensile steel castings. Pipelines for oil refinery, power plant at service temperature up to 600°C

Characteristics on Usage

A medium heavy coated controlled Carbon, low Hydrogen Iron powder type electrodes, welding in all position used for welding of similar Cr-Mo steel. Its deposition efficiency is 106% approximately, the weld metal is of radiographic quality and has creep resistance up to 600°C The weld metal gives 2.25% Cr and 1.0% Mo having excellent welding characteristics. Dry the electrodes at 300°C for obtaining best results.

Notes On Usage

- 1) Preheat at 200 - 350 °C and postheat at 690 ± 15 °C.
- 2) Dry the electrode at 350-400 °C for 60 Min- before use.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Mo %
0.050Max	0.90 Max	0.80 Max	0.030 Max	0.030 Max	2.0-2.50	0.90-1.20

Mechanical Properties Of Weld Metal

(After PWHT at 690 ± 15°C for 1 Hr soaking)

U.T.S.	Y.S.	ELONGATION	Creep strength	1% offset in 10000 Hrs
(N/mm ²)	(N/mm ²)	(L = 4d) %	AT 550 °C	AT 575 °C
550 Min	460 Min	17 % Min	12 Kg/mm ²	9.0Kg/mm ²

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50X350	150	600	AC/DC (+)	60-90
3.15X450	100	400		100-130
4.00X450	70	280		140-180
5.00X450	45	180		190-230