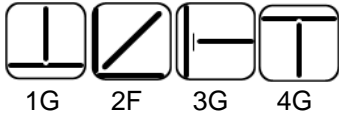


**Applications**

Since all Cr-Mo electrodes produce weld metal which will harden in still air, both preheat & postweld heat treatment are required for most applications. Specially design for Cr-MO Steels with high temp & pressure service condition in steam pipes of boilers. It is used for welding of Iron / 0.5 Mo, 0.5 Cr/0.5 Mo & similar creep resistance steels. Eg. ASTM A 335 – P11' pipe, ASTM A 387 Gr. II plate.

**Characteristics on Usage**

It is low hydrogen low alloy all position type flux cored wire with highly basic slag having stable & smooth arc, good slag detachability. Weld metal is of radiographic quality. It is used for all position welding with CO<sub>2</sub> shielding.

**Welding Positions**

1G 2F 3G 4G

**Recommended Stick Out**

15-20mm

**Shielding Gas**

Carbon Dioxide (CO<sub>2</sub>) shielding  
Gas Flow :20-25 Lit / Min

**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%	Cr %	Mo %
Typical Values	0.060	0.70	0.40	0.010	0.015	1.25	0.50
Spec. Reqd.	0.05-0.12	1.25 Max	0.80 Max	0.030 Max	0.030 Max	1.00-1.50	0.40 -0.65

**Mechanical Properties Of Weld Metal**

(After PWHT at 690 ± 15°C for 1 Hr)

Property	U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
Typical Values	600	545	24.50
Spec.Reqd.	550-690	470 Min	19 Min

**Welding Parameters (DC + VE)**

Diameter (mm)	Flat		Vertical - Up		Overhead	
	(A)	(V)	(A)	(V)	(A)	(V)
1.20	180-210	26-30	150-210	22-26	180-210	26-30
1.60	210-250	26-30	180-250	21-27	210-250	26-30

**Packing**

15 kgs. vaccum packed plastic spool.