

Applications

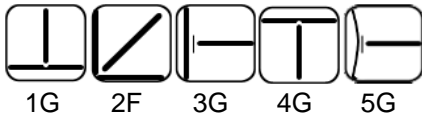
Suitable for joining of crack resistant steel, Low alloy steel. It is used for welding of pipelines in oil refineries, high temp. synthetic chemical industries, Electric power plant, Steam pipes of boiler tubes super heaters etc.

Characteristics on Usage

It is a low carbon hydrogen controlled basic coated iron powder type electrode operates in all position. It gives smooth and stable arc with easily removable slag. It gives low carbon content 1.20% Cr and 0.50% Mo type weld deposit with radiographic quality. the weld metal possesses excellent mechanical properties and resistance to cracking caused by heavy stresses of hydrogen.

Notes On Usage

- 1) Redry electrode at 250 °C for 2 hours.
- 2) Keep the arc as short as possible.

Welding Positions**Chemical Composition Of Weld Metal**

| C% | Mn% | Si% | S% | P% | Cr % | Mo % |
|----------|----------|----------|-----------|-----------|------------|-------------|
| 0.12 Max | 0.90 Max | 0.80 Max | 0.030 Max | 0.030 Max | 1.0 - 1.50 | 0.40 - 0.65 |

Mechanical Properties Of Weld Metal

(After P.W.H.T. at 690 ± 15°C for 1 Hr soaking period)

| U.T.S. (N/mm ²) | Y.S. (N/mm ²) | ELONGATION (L = 4d) % |
|--------------------------------|------------------------------|----------------------------|
| 520 Min | 390 Min | 19 Min |

Packing and Welding Current

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