

Applications

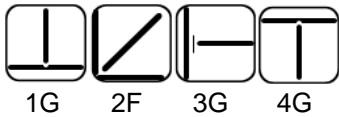
It is used for welding of 9% Cr, plates, pipe, tubes. It is also used for welding of 7 to 10% Cr, 1% Mo steel for general corrosion and heat resistance application. Surfacing of turbine Blades, Valve, Seats Pump parts etc.

Characteristics on Usage

A basic coated medium alloy low hydrogen electrode specially developed for welding of Ferritic, Martensitic chrome steels. It gives weld deposit which has contain 9% Cr, 1% Mo having excellent creep strength upto 625°C and resistance to oxidizing atmosphere upto 700°C. Proper preheating and post heating is required for weld made with these electrodes. The weld deposit gives radiographic quality of welds. Dry the electrodes at 300°C before welding to obtain best results.

Notes On Usage

- 1) Preheat at 200 - 350 °C and postheat at 740 ± 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 %	Ni %	Mo %
0.05 -0.10	1.00 Max	0.90 Max	0.030 Max	0.030 Max	8.0 – 10.50	0.40 Max	0.85 – 1.20

Mechanical Properties Of Weld Metal

(After PWHT at 740 ± 15°C for 1 Hr soaking)

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %
550 Min	460 Min	19 % Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 X 350	2	18	DC (+)	60 – 90
3.15 X 350	2	18		100 – 140
4.00 X 350	2	18		140 – 180
5.00 X 350	2	18		180 – 230

Packing

Vaccum packing