

Applications

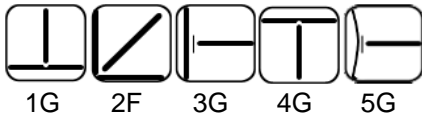
Suitable for joining of crack resistant steel, Low alloy steel. Welding on equipment of Oil Refineries, pipeline & high temperature synthetic chemical industries, Electric power plant , Steam pipes of Boilers, Tubes, Super heaters.

Characteristics on Usage

It is hydrogen controlled basic iron powder type all position electrode running with smooth & stable arc with easily detachable slag. It is designed for welds of radiographic quality and used in joining creep resistant steel and low alloy steel. The weld metal possess excellent mechanical properties and resistance to cracking caused by heavy stresses or hydrogen.

Notes On Usage

- 1) Redry electrode at 200-250 °C for one hours before welding.
- 2) Keep the arc as short as possible.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Mo %
0.05-0.12	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.	Y.S.	ELONGATION	Hydrogen (Mercury method)
(N/mm ²)	(N/mm ²)	(L = 4d) %	in 100grm weld metal
550 Min	460 Min	19 Min	5 ml Max

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50X350	150	600	AC/DC (+)	70-100
3.15 x 450	100	400		100-140
4.00X450	70	280		140-180
5.00X450	45	180		180-230