

Applications

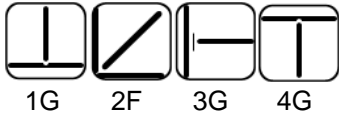
Suitable for welding 2.25% Cr, 1% Mo steels. Low alloy steel boilers and pipeline operation, Repair of high tensile steel castings. Pipelines for oil refinery, power plant at service , temperature up to 600 °C.

Characteristics on Usage

A medium heavy coated controlled Carbon, low Hydrogen Iron powder type electrode, welding in all positions. 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 electrode at 300 °C for obtaining best results.

Notes On Usage

- 1) Preheat at 150 - 250 °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 %
0.050 Max	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 S.R. at 690 ± 15°C for 1 Hr soaking)

U.T.S.	Y.S.	ELONGATION	Creep strength	1% offset in
(N/mm ²)	(N/mm ²)	(L = 4d) %	AT 550 °C	10000 Hrs
620 Min	530 Min	17 %	12 Kg/mm ²	AT 575 °C
				9.0 Kg/mm ²

Approvals**Packing and Welding Current**

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	150	600	AC / DC (+)	60 – 90
3.15 x 450	100	400		100 – 130
4.00 x 450	70	280		140 – 180
5.00 x 450	45	180		190 – 230