

**Applications**

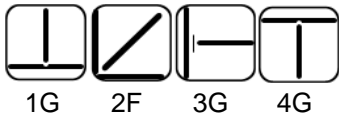
It is used for welding of 9% Cr, plates, pipes, tubes. It is also used for welding of 7 to 10% Cr, 1% Mo steel for general corrosion and heat resistance application. Surfacing of turbine Blades, Valve, Seats, Pump parts etc. A 213- T9 Tube , A335- P9 Pipe , P11&,A387 Grade.

**Characteristics on Usage**

A heavy coated low hydrogen electrode specially developed for welding of Ferritic, Martensitic chrome steels. It gives weld deposit which has contain 9% Cr, 1% Mo modified Nb/ V to provide improved creep strength, toughness, fatigue life & oxidation , orrosion resistance at elevated temperature. 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 150 - 250 °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 %
0.080 – 0.13	1.20 Max	0.30 Max	0.030 Max	0.030 Max	8.0 – 10.50	0.80 Max	0.85 – 1.20

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
620 Min	530 Min	17 % Min

**Approvals****Packing and Welding Current**

SIZE ( mm )	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 X 350	2	10	DC (+)	60 – 90
3.15 X 350	2	10		100 – 140
4.00 X 350	2	10		140 – 180
5.00 X 350	2	10		180 – 230

**Packing**

Vaccum packing