

Applications

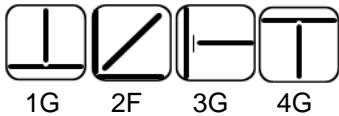
It is used for welding of 5% Cr, 0.5% Mo steel for high temp application in oil refineries. Power plants, Petrochemical plants. Fertilizer Industries.

Characteristics on Usage

A low hydrogen iron powder type basic coated all position electrode. It gives weld deposit which has contain 5% Cr, 0.5% Mo for the welding of similar Cr-Mo steel. The weld metal is of radiographic quality and has creep resistance upto 650 °C. Dry the electrode at 300 °C for obtaining best results.

Notes On Usage

- 1) Preheat at 150 - 250 °C and postheat at 690 ± 14 °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 %
0.05 – 0.09	0.50 – 0.90	0.25 – 0.50	0.030 Max	0.030 Max	4.0 – 6.0	0.45 – 0.65

Mechanical Properties Of Weld Metal

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

Approvals

K.N.P.C. ,IOCL

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	150	600	DC (+)	60-90
3.15 x 450	100	400		100-140
4.00 x 450	70	280		140-180
5.00 x 450	45	180		190-240