

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 steels, for general corrosion and heat resistance application, Surfacing of turbine Blades, Valve, Seats, Pump parts etc.,

Characteristics on Usage

A heavy coated low hydrogen electrode specially developed for welding of Ferritic, Martensitic chrome steels. It gives weld deposit which contains 9% Cr, 1% Mo having excellent creep strength up to 625 °C and resistance to oxidising atmosphere up to 700 °C. Proper preheating and post heating is required for welds made with these electrodes. The weld deposit gives radiographic quality of welds. Dry the electrode 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

1G 2F 3G 4G

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.05 – 0.10	1.0 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

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)	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

Vacuum packing