

**Applications**

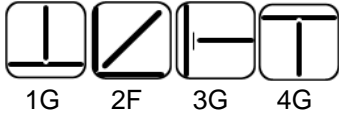
Suitable for Boilers welding, Pressure Vessels Pipe and Tubes, High Temp. Application upto 525° C

**Characteristics on Usage**

A low hydrogen, low alloy iron powder type basic coated all position electrode yielding a weld deposit containing 0.50%Mo. The weld metal is of radiographic quality and can withstand service temperature upto 525° C . smooth and weld rippled beads possessing excellent mechanical properties at room and at elevated temperature.

**Notes On Usage**

- 1) Dry the electrode a 350-400 °C for 60 Min- before use .
- 2) Preheat at 100 - 200 °C & post heat at 620 -680 °C
- 3) Keep the arc as short as possible.

**Welding Positions****Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Mo %
0.12 Max	0.90 Max	0.80 Max	0.030 Max	0.030 Max	0.40 - 0.65

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	IMPACT ( CVN ) AT R. Temp.(27 ± 2)
490 Min	390 Min	22 % Min	50 Joules Min

**Approvals**

L & T ,IBR

**Packing and Welding Current**

SIZE ( mm )	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	150	600	AC / DC (+)	70 – 90
3.15 x 450	100	400		100 – 130
4.00 x 450	70	280		140 – 190
5.00 x 450	45	180		190 – 240