

**Applications**

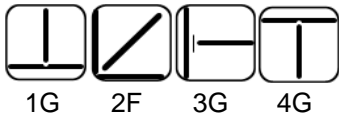
It is used for welding of 9% Cr, plates, pipes, tubes. It is also used for welding of 7 to 10% Cr, 1% Mo steels, for general corrosion and heat resistance application, Surfacing of turbine Blades, Valve, Seats, Pump parts etc.,

**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****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 <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
550 Min	460 Min	19 % Min

**Approvals**

K.N.P.C.

**Packing and Welding Current**

SIZE ( mm )	KG PER PACKET	KG PER CARTON	LBS PER PACKET	LBS PER CARTON	In Amps	Current (Amps)
2.50 X 350	5	20	11	44	60 – 90	DC (+)
3.20 X 350/450	5	20	11	44	100 – 140	
4.00 X 350/450	5	20	11	44	140 – 180	
5.00 X 350/450	5	20	11	44	180 – 230	

**Packing**

Vaccum Pack