

Applications

It is used for welding base material of similar composition Usually in the form of pipe or tubing.

Characteristics on Usage

It gives about 8.0 to 10.5% Chromium and 1.0 % Molybdenum type weld deposit. The alloy is an air hardening material and therefore when welding with this filler wire rod, preheat and post weld heat treatment are required

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.10Max	0.40 – 0.70	0.50 Max	0.025 Max	0.025 Max	8.0 – 10.50	0.50 Max	0.85-

Mechanical Properties Of Weld Metal

(After PWHT at 745 ± 15°C for 1 Hr soaking)

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %
550	470	17

Packing

Each Packets content 5 kg of Wire Rods having length 500 mm.,1000 mm.