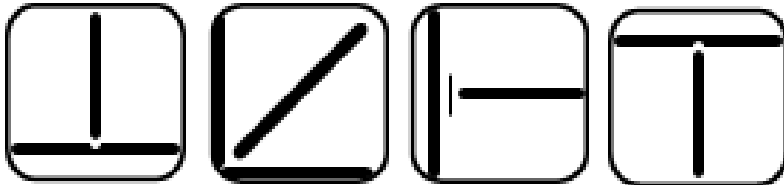


Applications

It is used for joining of dissimilar combination of Cr-Mo and carbon steel or used similar component of tube, pipe welding.

Characteristics on Usage

It gives about 1.50 % Chromium and 0.50 % 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

Welding Positions

1G

2F

3G

4G

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.07 -0.12	0.40 – 0.70	0.40 – 0.70	0.025Max	0.025Max	1.20 – 1.50	0.20 Max	0.40-

Mechanical Properties Of Weld Metal

(After PWHT at 620 ± 15°C for 1 Hr soaking)

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %
550	470	19

Packing

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