

**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 <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
550	470	17

**Packing**

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