

Applications

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

Characteristics on Usage

It gives about 4.50 to 6.0% 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**Shielding Gas**

Argon + 2% Oxygen

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %	V %	Cu %
0.10 Max	0.40 – 0.70	0.50 Max	0.025 Max	0.025 Max	4.50 – 6.00	0.60 Max	0.45- 0.65	0.030 Max	0.35 Max

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	19

Packing

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

Also Available in MIG Wire Size: 0.80mm, 1.00 mm, 1.20 mm in 5 kg and 12.5 kg spool.

Standard Wire Diameter

1.2mm, 1.6mm, 2.0mm, 2.5mm, 3.15mm