

Description

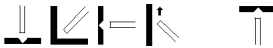
Basic low-hydrogen electrode for the AC/DC welding of creep-resistant steels of the 2.3% Cr/1% Mo type, such as SA – 387 Grade 22/A 335 Grade P22 or similar. The weld metal has the extra-low impurity levels specified in step-cooling requirements.

Recovery

110%

Welding current

AC, DC+ OCV 65 V



Packing/Ordering Information

| Part Number | Dia mm | Inner Carton | Carton Weight (kg) | Pallet Weight (kg) |
|-------------|--------|--------------|--------------------|--------------------|
| 76263230G0 | 3.2 | 1.6 | 9.6 | 643.2 |
| 76264040G0 | 4.0 | 2.1 | 12.6 | 617.4 |
| 76265040G0 | 5.0 | 2.2 | 13.2 | 646.8 |

Classifications

| | |
|--------------|-----------------|
| SFA/AWS A5.5 | E9018-B3 |
| EN 1599 | E CrMo2 B 42 H5 |

Typical all weld metal composition, %

| C | Si | Mn | Cr | Mo |
|------|-----|-----|-----|-----|
| 0.08 | 0.3 | 0.7 | 2.3 | 1.1 |

Typical properties of all weld metal (Stress Relieved)

| | |
|-----------------------|-----|
| Yield stress, Mpa | 650 |
| Tensile strength, MPa | 740 |
| Elongation, % | 18 |

Charpy V

| Test temps, °C | Impact values, J |
|----------------|------------------|
| -20 | 60 |

Welding parameters



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| Diameter, mm | Length, mm | Welding Current, A | Arc Voltage, V | IV. | IV. | IV. | IV. |
|--------------|------------|--------------------|----------------|------------------------------|------------------------------------|------------------------------|----------------------------------|
| | | | | Kg Weld Metal/(kg Electrodes | No. of Elec- todes/ (kg Weld metal | Kg weld Metal/(hour Arc Time | Burn-off time, (secs)/ Electrode |
| 3.2 | 350 | 90-130 | 23 | 0.60 | 49 | 1.11 | 66 |
| 4.0 | 450 | 130-190 | 25 | 0.61 | 23 | 1.90 | 83 |
| 5.0 | 450 | 150-260 | 27 | 0.62 | 15 | 2.60 | 92 |