

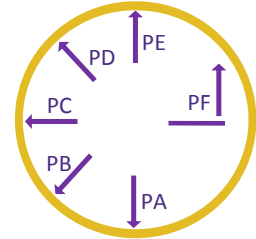
Applications

- Suitable for the welding of high temperature and high pressure pipe.
- For synthetic chemical machinery, petroleum cracking equipments working under 550°C, such as A335-P22 pipe, A387 Gr.22 plate.

Features

- Good mechanical properties and good creep resistance.
- Iron powder and low hydrogen type electrode (High efficiency)
- Stable arc, Few spatter, beautiful weld bead appearance.
- Easy slag removal and high X-ray pass rate.

Welding Position



Typical Chemical Properties of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.07	0.35	0.75	0.011	0.013	2.28	1.05

Typical Mechanical Properties of All-Weld Metal

Ys MPa	TS MPa(lbs/in ²)	EL (%)	Heat Treatment
575	675	19.5	690°C x1hr S.R

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	350 (14)	450 (18)	450 (18)	450 (18)
F	70-120	90-130	140-190	170-220
V-up, OH	60-100	80-120	120-160	

Current

AC or DC ±

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Notes on Usage

- Please follow the low alloy electrode usage guideline.
- Preheat and interpass temperature: 160-190°C.

Packing Details

4Kg Pack / 16 Kg Ctn (Vacuum Packing)