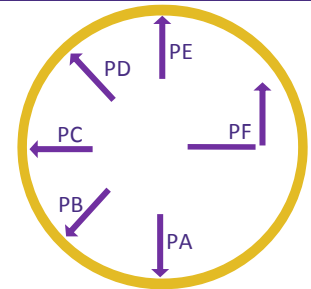


Applications

- Stainless steel (321,347)
- Energy & Power Plants

Features

- Contains stabilizing element (Nb).
- High temperature strength.
- Suitable for welding of boiler and gas turbine.
- Easy to slag remove.



Typical Chemical Properties of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Nb
0.02	0.75	0.82	0.027	0.014	19.3	9.8	0.35

Typical Mechanical Properties of All-Weld Metal

TS MPa	EL (%)
603	42.4

Diameter mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (12)	350 (14)	350 (14)	350 (14)	350 (14)
F & HF	25-55	50-85	70-115	95-145	135-180
V-up, OH	20-50	45-80	65-110	85-135	

Current

AC or DC ±

Redrying Condition

350°C (662°F) x 1hr

Packing Details

2Kg Vacuum Packing & 10Kg Ctn