

### Applications

- High pressure pipe & Pressure vessels.

### Features

- Careful control of preheat, interpass temperature, postheat is essential to avoid cracking.
- For welding 2.25Cr-1.0Mo steels for elevated temperatures and corrosive service.
- X-factor value of wire is 10ppm or less.

### Typical Chemical Composition of weld metal (wt%)

C	Si	Mn	P	S	Ni	Cr	Mo
0.085	0.54	0.59	0.012	0.010	0.04	2.46	1.04

### Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Ys Mpa	TS MPa	E L (%)	Temp °C	CVN- Impact Value (J)
As welded with 100% Ar	560	640	25	-20	197

### Dimensions and Packing Details

2.0mm x1000mm 5KgTube  
2.4mm x1000mm 5KgTube  
3.2mm x1000mm 5Kg Tube

### Current

DC-