ROWELD-CR2

LOW HYDROGEN TYPE ELECTRODE FOR ALL-POSITION WELDING WHICH PROVIDES THE WELD METAL 2.25% CR-1% MO.

BASIC ALLOY: FE, CR,MO
AWS/SFA-5.5: E 9018 B3
EN ISO 3580-A E CRMO2B 32 H5

KEY FEATURES:

A medium heavy coated, hydrogen controlled, iron powder type, all position radiographic quality electrode to weld 2.25% Cr-1.00% Mo steel, having increased working efficiency. Electrode has properties of creep resistance up to 575°C.

APPLICATIONS

- Suitable to weld high tensile.
- Low alloy steels with 2.25% Cr and 1% Mo used in oil refinery/ power plants, steam boilers.
- Equipment's subjected at high temperatures in synthetic chemical units.
- Repairs of cast steel components.
- Parts of automobiles / earthmoving machineries.
- Includes marine applications

RE-DRY CONDITION:

- Re-Dry the electrode at -350°C for one hour before use.

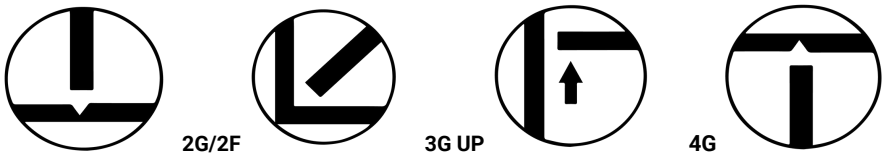
CHEMICAL COMPOSITION:

C	Mn	Si	Cr	Mo	S&P
0.05-0.12	0.90 Max.	0.60 Max	2.00-2.50	0.90-1.20	0.030 Max

MECHANICAL PROPERTIES:

YS (N/mm2)	UTS (N/mm2)	EL % (l=5d)
530 min.	620 Min.	20 min

WELDING POSITION



1G/1F 2G/2F 3G UP 4G

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia	Size(inch) (Dia)	Current Condition (DC+/AC) Amps	Kg./pkt.	KG/Case
2.50/ 2.40	3/ 32"	**70-100**	5	20
3.15/ 3.20	1/ 8"	**100-130**	5	20
4.00	5/ 32"	140-180	5	20
5.00	3/ 16"	190-230	5	20