SR-78A1

AWS A5.5 E7018-A1
EN ISO 3580-A E Mo B 3 2
GB T5118 E5018-A1

HEAT-RESISTANT LOW-ALLOW STEEL SMAW

DESCRIPTION & APPLICATIONS :

- SR-78A1 is a 490N/mm^2 iron powder low hydrogen electrode.
- It can provide high welding efficiency because of additional iron powder. Suitable for alloy with 0.5% Mo under high temperature and pressure.
- Suitable for ATPA12, A335-P1 of Steel Pipes, STBA 12, A209-T1, A161-T1 of heat exchanger, A217-WCI casting steel and A182-F1, A366-F1 of forging steels.

NOTE ON USAGE :

- Proper preheat at 100 ~ 200°C and PWHT at 620 ~ 680°C.
- Rebake the electrodes at 350 ~ 400°C for 60 minutes and keep at 100 ~ 150°C before use.
- Take the backstep method to prevent blowholes at the arc starting.

WELDING POSITION :

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Mo
0.070	0.62	0.66	0.016	0.009	0.55

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YIELD POINT N/mm^2(Kgf/mm^2)	TENSILE STRENGTH N/mm^2(Kgf/mm^2)	ELONGATION RATE %	HEAT TREATMENT
535 (54.6)	610 (62.2)	29	620°Cx1hr

SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	400	400
Current (Amp)	F	90-130	140-180	190-220
	V & OH	80-120	120-160	-