

HEAT-RESISTANT LOW-ALLOY STEEL SMAW

DESCRIPTION & APPLICATIONS :

- SR-86B2 is a basic coated low hydrogen electrode for heat resistant low alloy steel.
- The electrode can weld in all position and suitable for welding 1.25%Cr-0.5%Mo heat resistant steels with operating temperature above 550C.
- The weld metal SR-86B2 can be applied for ASTM A193 Gr. B7; A335 Gr. P11 a. P12; A217.

NOTE ON USAGE :

- Proper preheat at 150 ~ 300°C and PWHT at 650 ~ 700°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	Cr	Mo
0.07	0.51	0.45	0.016	0.005	1.20	0.52

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
560(57.1)	650(66.3)	26	690°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	90-140	140-180	190-220
	V & OH	80-120	120-160	-