

HEAT-RESISTANT LOW-ALLOY STEEL SMAW

DESCRIPTION & APPLICATIONS :

- SR-86B6 is a basic low hydrogen electrode for heat resistant low alloy steel.
- As its weld metal contains 5%Cr-0.5%Mo, SR-86B6 has good performance of heat resistance.
- Suitable for ASTM A387 Gr. 5 for refineries, JIS SCM56 for petro-chemical and power plants.

NOTE ON USAGE :

- Proper preheat at 250 ~ 350°C and PWHT at 710 ~ 760°C.
- Reheat the electrodes at 350 ~ 400°C for 60 minutes and keep at 100 ~ 150°C before use.
- Keep the arc as short as possible. Please take the method of back-forward.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Cr	Mo
0.08	0.55	0.3	0.013	0.006	5.58	0.57

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
640(65.3)	680(69.4)	22	740°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	180-210
	V & OH	80-120	120-160	-