

HEAT-RESISTANT LOW-ALLOY STEEL SMAW

DESCRIPTION & APPLICATIONS :

- SR-88B2 is an iron powder low hydrogen electrode designed for welding heat resistant low alloy steel.
- The electrode coated by iron powder marks characteristics of high working efficiency suitable for welding steel with 1.25%Cr-0.5%Mo.
- SR-86B2 is suitably applied for ASTM A193 Gr. B7; A335 Gr. P11 a. P12; A217 Gr. WC6.; A336 Gr. F12.

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
0.08	0.59	0.46	0.016	0.005	1.28	0.49

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
568(58.0)	660(67.3)	27	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	-