

HEAT-RESISTANT LOW-ALLOY STEEL SMAW

DESCRIPTION & APPLICATIONS :

- SR-98B3 is an iron powder low hydrogen electrode for heat resistant low alloy steel.
- Thanks to its high working efficiency contributed from iron powder, it's suitable for the weld containing 2.25%Cr-1%Mo under high temperature.
- Suitable for welding high temperature and pressure thick pipes, pipes for boiler heat exchanger, extended steel, steel casting, and forged steel.

NOTE ON USAGE :

- Proper preheat at 200 ~ 350°C and PWHT at 680 ~ 730°C.
- Rebake 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
0.06	0.40	0.26	0.016	0.007	2.35	1.06

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
629(64.2)	692(70.6)	21	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	-