

LOW ALLOY STEEL (High Temperature)

CLASSIFICATION:

EN ISO 3580-A
E CrMo1 B 32 H5

IS 1395
E 55B-B2

KEY FEATURES:

- Basic coated iron powder electrode
- 1.25Cr-0.5Mo type weld deposit
- Resistant to creep and heat upto 550°C
- Preheat and interpass temperature of 150-200°C followed by PWHT
- Radiographic quality weld deposit
- Positional welding capability

APPROVALS: ABS/IBR/NPCIL/BHEL/NTPC/CE

TYPICAL APPLICATIONS:

- Welding of 1.25Cr-0.5Mo, 1Cr-0.5Mo steels in refineries, power plants, chemical plants
- Pressure vessels and Boilers
- Cr and Cr-Mo bearing steels at elevated temperature service e.g. steam production plants, steam pipes
- Joining P4 materials e.g. ASTM SA 182/182M Gr.F2/F11/F12, SA 213/213M Gr.T11/T12, SA 335/335M Gr.P11/P12, SA 387/387M Gr.2/11/12
- Suitable for 13CrMo44, 15CrMo5, 15Cr3, 16MnCr5, 20MnCr5

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

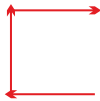
C	Mn	Si	Cr	Mo
0.06	0.7	0.6	1.3	0.5

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at 27°C, J
Typical	PWHT: 690°C for 1 hr.	615	525	24	70
Specification		550 min	460 min	19 min	-

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm 2.5 x 350 3.15 x 350 4.0 x 450 5.0 x 450	Amperage, A 60-90 100-140 140-180 190-250	 AC (70 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
---	--	--	---

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kgs each. Also available in vacuum packing

EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
Automig 80S-B2	Tigfil 80S-B2	Automig FC 81 T1 - B2	Flux	Wire
			Automelt B20 Plus	Automelt EB2