

VALIANT

VALIANTTHERM CR I

AWS:A5.5: E8018B2 IS-1395:E55BB226Fe

A medium heavy coated, hydrogen controlled, iron powder type, all position radiographic quality electrode to weld 1.25% Cr-0.50% Mo steel, having increased working efficiency. Electrode has properties of creep resistance upto 550°C.

CHEMICAL COMPOSITION

C	Mn	Si	Cr	Mo
0.06	0.80	0.44	1.35	0.55

MECHANICAL PROPERTIES

UTS (Kg/mm ²)	YS (Kg/mm ²)	EI (L = 4D) %	Creep strength at 550°C
60.0	52	25	12 Kg/mm ²

WELDING PARAMETERS

	Size (mm)	Current (Amp.)
AC/DC (-)	5.00 X 450	180-240
	4.00 X 350	140-180
	3.15 X 350	100-130
	2.50 X 350	70-100

APPLICATION

Suitable for weld creep resistance steels like Cr-Mo pipelines and plates used in oil refinery, powerplants, steam boilers, equipment subjected at high temp, in synthetic chemical units, parts of automobile, earth moving machineries.

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