

VALIANT

VALIANTTHERM CR 2

AWS:A5.5:E9018B3 IS-1395 : E63 BB 326Fe

A medium heavy coated, hydrogen controlled , iron powder type, all position radiographic quality electrode to weld 2.25% Cr-1.00% Mo steel, having increased working efficiency. Electrode has properties of creep resistance upto 575°C.

CHEMICAL COMPOSITION

C	Mn	Si	Cr	Mo
0.07	0.85	0.45	2.30	1.10

MECHANICAL PROPERTIES

UTS (Kg/mm ²)	YS (Kg/mm ²)	EI (L = 4D)%	Creep strength at 575°C
65.0	56	22	8.5 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 high tensile, low alloy steels with 2.25% Cr and 1% Mo used in oil refinery, powerplants, steam boilers, equipment subjected at high temp, in synthetic chemical units, parts of automobile, earth moving machineries, also includes marine applications.

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