

# VALIANT

## VALIANTTHERM CR 9

AWS:A5.5:E8018B8 IS-1395 : E41 BB 826Fe

A basic coated, hydrogen controlled, iron powder type electrode producing 9% Cr-1.0% Mo deposit. Well deposit is of radiographic quality, highly resist to corrosion, oxidation and exhibits creep resistance property at elevated temp, upto 600°C. The finish is excellent.

### CHEMICAL COMPOSITION

| C    | Mn   | Si   | Cr  | Mo   |
|------|------|------|-----|------|
| 0.06 | 0.60 | 0.40 | 9.0 | 0.90 |

### MECHANICAL PROPERTIES

| UTS<br>(Kg/mm <sup>2</sup> ) | EI<br>(L = 4D )% | Creep strength at<br>600°C |
|------------------------------|------------------|----------------------------|
| 49                           | 25               | 6.5Kg/mm <sup>2</sup>      |

### WELDING PARAMETERS

|           | Size<br>(mm) | Current<br>(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

Application include welding of 7 to 10% Cr-1 % Mo steels and castings of similar composition.

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