AI-0190

Specifications

AS/NZS 1553.2 : E6218-B3 H5R
AWS/ASME A5.5 : E9018-B3 H4

Description and Applications

2.25Cr-1Mo content to be used for the welding of creep resistant steel.
It is used in chemical industry and in the ammonia synthesis process, for heat exchangers, boilers, piping and pressure vessels for temperature service up to about 600°C. It will also find application in the petro-chemical industries, suitable for facing on casting and for casting repairs.

Typical Weldmetal Analysis

C	Mn	Cr	Fe	P	Si	Mo
0.065	0.7	2.3	Bal	0.01	0.4	1

Mechanical Properties of Weldmetal

	As Welded
Tensile Strength	660MPa
Yield Strength (0.2%)	680Mpa
Elongation	>22% (4d)

Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC / AC	60
3.2	DC / AC	110

Preheat and interpass temperature 175°C. PWHT at 690°C for an hour. To be reconditioned at 300-350°C for 2 hours (max 3 times) if necessary.

Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4F) Horizontal overhead position, (4G) Overhead position & (3G, 3F, 5G up) Vertical Position Up

Disclaimer

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