

HEAT-RESISTANT LOW-ALLOY STEEL SMAW

DESCRIPTION & APPLICATIONS :

- SC-70A1 is a low hydrogen electrode for the welding of 490N/mm² grade high tensile steel.
- It can be used for welding of 0.5%Mo steel used for high temperature and pressure application.
- It can be used for high pressure boilers, chemical industries, oil refining industries and turbine casting.

NOTE ON USAGE :

- Proper preheat at 100 ~ 200°C and PWHT at 620 ~ 680°C.
- Rebake the electrodes at 70 ~ 80°C for 30 ~ 60 minutes before use.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Mo
0.093	0.41	0.23	0.016	0.009	0.55

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YIELD POINT N/mm ² (Kgf/mm ²)	TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	HEAT TREATMENT
510(52)	570(58.2)	27	620°Cx1hr

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	350	350
Current (Amp)	F	80-120	110-170	150-200
	V & OH	70-110	90-150	-