

LOW TEMPERATURE-SERVICE LOW-ALLOY STEEL SMAW

DESCRIPTION & APPLICATIONS :

- SR-86C1 is a low hydrogen electrode for low temperature service low alloy steel.
- For all welding positions. With good impact performance down to -60°C and good mechanical properties.
- Suitable for low temperature machine, welding of aluminum killer steel and 2.5%Ni steel. For instance JIS G3127 SL2N 255.

NOTE ON USAGE :

- Proper preheat at 100~150°C and PWHT at 600~630°C.
- Rebake the electrodes at 350 ~ 400°C for 60 minutes and keep at 100 ~ 150°C before use.
- Keep the arc as short as possible. Please take the method of back-forward.
- Set up current in a recommended range to obtain impact value.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni
0.06	0.68	0.30	0.013	0.006	2.20

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YIELD POINT N/mm ² (Kgf/mm ²)	TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	IMPACT VALUES -60 °C J(Kgf-m)	HEAT TREATMENT
530(54.1)	590(60.2)	28	64(6.5)	605 °C x 1 hr

SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	400	400
Current (Amp)	F	100-140	140-180	180-210
	V & OH	90-120	120-160	-