

HEAT-RESISTANT LOW-ALLOY STEEL SMAW

DESCRIPTION & APPLICATIONS :

- SR-76A1 is a low hydrogen electrode alloyed with 0.5% Mo for welding steels of pressure vessels.
- It is suitable for welding 0.5%Mo steel used at high temperature and high pressure.
- It can be used for ATPA12, A335-P1 of Steel Pipes, STBA 12, A209-T1, A161-T1 of heat exchanger, A217-WCI casting steel and A182-F1, A366-F1 of forging steels.

NOTE ON USAGE :

- Proper preheat at 100 ~ 200°C and PWHT at 620 ~ 680°C.
- Rebake the electrodes at 350 ~ 400°C for 60 minutes and keep at 100 ~ 150°C before use.
- Take the backstep method to prevent blowholes at the arc starting.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Mo
0.068	0.60	0.68	0.015	0.008	0.50

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
530(54.1)	600(61.2)	28	620°Cx1hr

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

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	400	400
Current (Amp)	F	90-130	140-180	190-220
	V & OH	80-120	120-160	-