

HEAT-RESISTANT LOW-ALLOY STEEL SMAW

DESCRIPTION & APPLICATIONS :

- SR-86B8 is a low hydrogen electrode for heat resistant low alloy steel.
- As its weld metal contains 9%Cr-1%Mo, SR-86B6 has good performance of heat resistance.
- Suitable for refineries, petro-chemical.

NOTE ON USAGE :

- Proper preheat at 250 ~ 350°C and PWHT at 710 ~ 760°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.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Cr	Mo
0.07	0.53	0.29	0.016	0.005	9.60	0.9

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
560(57.1)	670(68.4)	22	740°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	180-210
	V & OH	80-120	120-160	-