RATNA CR 9 SPL

Hydrogen controlled iron powder Electrode for welding Creep-Resistant with High alloyed, 9Cr-1Mo steels.

CLASSIFICATION : AWS/SFA-5.5: E 9016 B9

APPROVAL :

CHARACTERISTICS : A basic coated, hydrogen controlled, iron powder type electrode, producing 9% Cr / 1.0% Mo deposit. Weld deposit is of radiographic quality, highly resist to corrosion, oxidation and exhibits creep resistance property at elevated temp. up to 600°C. The finish is excellent.

APPLICATION :

1) Ideally **s**uitable for oil refinery petrochemical industries, chemical industries.
2) Power house applications where steels of similar compositions are used.
3) For welding 7-10% Cr 1% Mo steels and castings of similar compositions.

RE-DRY CONDITION : Re-Dry the electrode at 350°C for 1 hrs before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Mo
0.08-0.13	1.20 Max	0.30 max	0.010 Max	0.010 Max	8.00-10.50	0.85-1.20
Ni	V	Cu	Nb	N		
0.80 Max.	0.15-0.30	0.25 Max.	0.02-0.10	0.02-0.07		

ALL WELD MECHANICAL PROPERTIES (PWHT 760°C/ 2Hrs):

YS (N/mm^2)	UTS (N/mm^2)	EL % (l=4d)
530 Min.	620 Min.	17 Min.

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+) Amps	No. of Pcs./pkt.	No. of Pcs./Case
2.50/ 2.40 X 350	3/ 32" X 14"	60-80	170	640
3.15/ 3.20 X 450	1/ 8" X 18"	100-140	110	440
4.00 X 450	5/ 32" X 18"	140-180	70	280
5.00 X 450	3/ 16" X 18"	190-240	48	192

Customer packing on request.