

AKR317

Description: Low-hydrogen-sodium-coated low-alloy heat-resistant steel electrodes have excellent welding processability and can be welded in all positions. The welded joint has high strength, good oxidation resistance when it is lower than 600C, high temperature strength, excellent creep resistance and fatigue resistance, good operability of welding rod, suitable for onsite installation and construction. The deposited metal is pure, such as S, P and other impurities are extremely low, $S \leq 0.010\%$ $P \leq 0.012\%$. Meet the requirements of GB/T5118E5515-1CMV related items.

Application: It is suitable for welding chromium-molybdenum-vanadium vanadium pearlitic heat-resistant steel (1Cr-0.5Mo 0.25V) steel plates for largescale equipment with harsh service conditions and complex corrosive media such as petrochemical, coal chemical, and thermal power plants.

Typical Chemical Composition(%):

	C	Mn	P	S	Si	Cr	Mo	V	As	Sn	Sb
Actual Result	0.08	0.76	0.008	0.003	0.21	1.27	0.58	0.23	0.003	0.001	0.001

Typical Mechanical Properties : ①=normal temperature/heat treatment: 730℃×2h

℃	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact values (J) 20℃
①	650	565	23	149 138 169
475	—	490	—	

Notes on Usages:

1. The electrodes must be baked at 350~380℃ for an hour before welding and used as soon as baking is completed.
2. The stains on the weldments, such as rust, oil stains, moisture, etc., must be cleared away before welding