

D&H 13Cr

CODIFICATION : AWS : SFA 5.4 E410-15

CHARACTERISTICS AND APPLICATIONS :

D&H 13Cr is a special flux coated hydrogen controlled electrode depositing 13Cr weld metal. Ideally suited for joining similar alloys, resurfacing of valve seats, steam and gas turbine components. Ideal for joining straight chromium stainless steels.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	:	C	Mn	Si	Cr	Ni	S	P
Percent	:	0.07	0.80	0.60	12.5	0.35	0.020	0.020

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 750°C FOR 1 HR)

UTS	Elongation
(MPa)	(L= 4d)%
554	25.0

CURRENT AND PACKING DATA: DC(+)

Size (mm)	:	5x350	4x350	3.15x350	2.5x350
Dia x Length					
Current Range	:	180-220	130-170	90-120	60-80
(Amps)					
Weight/Cartron	:	2.5	2.5	2.5	2.5
(kgs)					

APPROVAL: BHEL, CIB-MP, Reliance (SASAN Power)

PRECAUTIONS:

1. Ensure the electrodes are dry. In case of moisture pick-up, redry the electrodes at 250-300°C for one hour.
2. Use minimum current and stringer bead.