

## D&H 17Cr

**CODIFICATION :**                      AWS    :    SFA 5.4 E430-15

### CHARACTERISTICS AND APPLICATIONS :

D&H 17Cr is a heavy coated low hydrogen electrode depositing a weld metal containing 17Cr. The weld deposit displays good resistance to corrosion and heat. The electrode is suitable for joining stainless steels of similar composition. It is also suitable for surfacing carbon steels, low alloy steels and chromium steels. Typical applications include surfacing of valves, impellers, turbine blades, etc.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	:	C	Mn	Si	Cr	Ni	S	P
Percent	:	0.075	0.60	0.50	17.0	0.35	0.020	0.020

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

**(PWHT: 780°C FOR 2 HRS)**

UTS	Elongation
(MPa)	(L= 4d)%
485	20.0

### CURRENT AND PACKING DATA: DC(+)

Size (mm)	:	5x350	4x350	3.15x350	2.5x350
Dia x Length					
Current Range	:	130-170	100-130	80-110	70-90
(Amps)					
Weight/Carton	:	2.5	2.5	2.5	2.5
(kgs)					

### APPROVAL: BHEL

### 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.