

MOLYTHERME-R

CODIFICATION : IS : 1395 E 63 B D1 26 J

CHARACTERISTICS AND APPLICATIONS :

Molytherme-R is a low hydrogen electrode yielding a weld deposit containing Mn-Mo. The electrode is ideally suited for welding steels of similar composition, CONCOR BOGIES etc. The weld metal possesses good high temperature properties and has excellent toughness. The deposits will also meet the metal recovery of 110% min. requirements.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	:	C	Mn	Si	Mo	S	P
Range (%)	:	0.06	1.30	0.50	0.40	0.020	0.021

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 620°C FOR ONE HR)

UTS	YS	Elongation	RA%	CVN Impact Strength
(MPa)	(MPa)	(L = 5d)%		at minus 50°C (J)
640	550	23.0	65.0	40

CURRENT AND PACKING DATA : AC / DC(+)

Size (mm)	:	6.3x450	5x450	4x350	3.15x350	2.5x350
Dia x Length						
Current Range	:	270-340	170-240	140-170	100-130	70-90
(Amps)						
Qty.(Pcs./Carton)	:	25	35	55	75	125

PRECAUTIONS :

1. Re bake the electrodes at 250-300°C for 1 hr.
2. Use short arc and stringer bead.