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 (MPa) YS (MPa) Elongation (L = 5d)% RA% CVN Impact Strength 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 (Amps): 270-340 170-240 140-170 100-130 70-90
Qty.(Pcs./Carton): 25 35 55 75 125

PRECAUTIONS:
1. Rebake the electrodes at 250-300°C for 1 hr.
2. Use short arc and stringer bead.