



MODI CROMO-V

LOW HYDROGEN ELECTRODE

CHARACTERISTICS : An outstanding welding electrode for higher strength steels with a requirement of tensile strength more than 63 kg/mm². Coating is low hydrogen type and specially formulated to resist moisture pick up under condition of high heat and humidity. Due to resistance to moisture pick up, hydrogen cracking and starting porosities are avoided. The welds are of radiographic quality giving excellent strength and creep resistance up to 550°C. Metal recovery is above 110%

APPLICATIONS :

- * Welding of Creep Resistance of Cr-Mo and Cr-Mo-V type.
- * Steam Boilers
- * Steam & Superheater Piping
- * Power Plants
- * Oil Refineries
- * Chemical Plants

RECOMMENDATIONS : Re-dry the electrodes at 350°C to 400°C for one hour. Keep the re-dried electrode in a holding oven at 50°C-60°C temperature. Use the electrode directly from the holding oven. The pre-heat and interpass temperature should be maintained between 160°C-190°C. The welded section has to be stress relieved at 660°C for at least one hour.

CHEMICAL ANALYSIS OF WELD-METAL(%) :	C	Mn	Si	Cr	Mo	V	S	P
	0.1-0.15	1.0	0.5	1.0-1.5	0.9-1.3	0.2-0.3	0.02	0.02
		max	max				max	max

MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER AWS/A 5.5) :	Yield Strength	Ultimate Tensile Strength	Elongation (GL=4d) (%)	CVN Impact Values at 20°C
	N/mm ²	N/mm ²		Joules
	530 min	620 min	16 min	27 min

CURRENT CONDITIONS : USE DC (+) ONLY

Size (mm)	2.5x350	3.15x450	4.0x450	5.0x450	6.3x450
Amps	80-110	110-140	140-180	180-220	240-280



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