

ROYAL (Ni) CHROME (E 10016 G)

AWS : SFA 5.5, E 10016 G IS : E G8BG126 EN ISO 18275 A E 62 3 Z B 32 H5

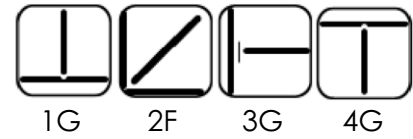
Applications

It is used for welding earth moving equipment's. Steam turbine, rotors of chemical plants. Heavy machinery parts made of high tensile steel. Automotive parts and armour steel of Ni-Cr-Mo based.

Characteristics on Usage

It is a hydrogen controlled medium heavy coated all position electrode. It has better creep resistance properties as well as corrosion resistance properties. It gives weld deposit which contain 1% of Cr & 2.5% of Ni. The weld metal is of radiographic quality and possess excellent strength combined with good toughness. This electrode is used for welding of high tensile, low alloy steels, which contains Ni-Cr-Mo types. Therefore, it is used in Chemical plants, especially for the welding of steam turbine, rotors etc. Redry the electrodes at 300 °C about an hour for better results

Welding Positions



Notes On Usage

- ⌚ Dry the electrode at 250 - 300 °C for 60 Min-before use.
- ⌚ Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose.
- ⌚ Preheat at 100 - 150 °C The temp. varies in accordance with plate thickness and kind of steel.

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.10 Max	1.00 Min	0.20 – 0.50	0.030 Max	0.030 Max	0.8 – 1.20	2.20 – 2.80	0.60–0.90

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT R. Temp.(27 ± 2)
690 Min	600 Min	16 % Min	50 Joules Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	AC/DC (+)	60-90
3.15 x 450	5	20		100-140
4.00 x 450	5	20		140-180
5.00 x 450	5	20		180-230