



## SUNTHERM CR 1

### CLASSIFICATION:

AWS: A 5.5: E 8018B2  
IS 1395: E 55 BB 226Fe

### DESCRIPTION:

SUNTHERM CR1 is a basic coated, hydrogen controlled, iron powder type, all position radiographic quality electrode to weld 1.25% Cr-0.5% Mo steel, having increase working efficiency. Electrode has properties of creep resistance upto 550\* C.

### TYPICAL ALL WELD METAL PROPERTIES:

Chemical Composition (%)				Mechanical Properties	
C	0.05-0.12 max	Mn	0.50-0.90	YS	48-56 Kg/mm <sup>2</sup>
Si	0.50 max	S	0.03 max	UTS	58-68 Kg/mm <sup>2</sup>
P	0.03 max	Cr	1.0-1.50	EL (L=4d)	20-28%
Mo	0.40-0.65			Hydrogen in Weld metal	5 ml/100 g max

### TYPICAL APPLICATIONS:

Suitable for weld creep resistance steels like Cr-Mo pipelines and plates used in oil refinery, power plants, steam boilers, equipment subjected at high temperatures in synthetic chemical units, parts of automobile, earth moving machinery. Steels of the type ASTM A 182-F2, A387-2,A213-72,A335 P2.

### CURRENT RANGE & PACKING DATA:

Size	Length	Current Range	Qty of Electrodes in a	Qty of Electrodes in a
(mm)	(mm)	(Amps)	Carton	Cardboard box
2.5	350	70-110	5 Kg	20 Kg
3.15	450	100-130	5 Kg	20 Kg
4.00	450	140-180	5 Kg	20 Kg
5.00	450	180-250	5 Kg	20 Kg

### PACKING:

Electrodes are packed in Cartons and four of these Cartons are shrink wrapped in a cardboard box.