

ESAB CHROMWELD G

A rutile coated 19/8/5 type electrode for joining dissimilar steels

Classification IS 5206: E 18.8 Mn R 24



DESCRIPTION

ESAB Chromweld G is a rutile coated stainless steel electrode depositing 19 Cr-8 Ni-5 Mn work hardening type weldmetal. The electrode is specially designed for applications involving good work hardening properties and joining of high tensile steels. It has smooth and stable characteristics with good bead appearances.

APPROVALS: RDSO

WELDING CURRENT: DC +, AC 70V

TYPICAL APPLICATIONS

Chromweld G is specially designed for welding of High strength steels of unknown composition and also suitable as a cushioning layer prior to hard surfacing. Other applications include joining of manganese steel to manganese steel or mild steel, in marine shaft building, bucket lips, etc.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.10	Ni	9.0	UTS	650 N/mm ²
Mn	6.20	Cr	20.50	YS	500 N/mm ²
Si	0.60	P	0.020	EL (L=4d)	35%
S	0.015				

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.5	350	50-80	80	400
3.15	350	90-130	60	300
4.00	350	110-150	40	200
5.00	350	130-180	25	125

PACKING: Electrodes are packed in heat sealed plastic cartons and five of these cartons are shrink wrapped in a cardboard box.