

COMWELD CrMo2



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

| | |
|---|-----------------|
| Welding Grade Argon: | |
| 0.2% Proof Stress | 560 MPa. |
| Tensile Strength | 670 MPa. |
| Elongation (in 2 inches) | 18% |
| CVN Impact Values | 60 J av @ +20°C |
| Post weld heat treated at 690°C as required by AWS A5.28. | |

TYPICAL ROD ANALYSIS:

| | | |
|-----------|-------------|-----------|
| C: 0.08% | Mn: 0.70% | Si: 0.60% |
| Cr: 2.50% | Mo: 1.00% | P: 0.015% |
| S: 0.010% | Fe: Balance | |

COMPARABLE CIGWELD PRODUCTS:

Alloycraft 90-B3 electrode
AWS A5.5: E9018-B3

- ▲ Nominal 2 1/2CR1Mo steel TIG rod.
- ▲ End Stamped with AWS Class 'ER90S-B3' for Easy Identification.
- ▲ For the Gas Tungsten Arc (TIG) Welding of Cr-Mo and Cr-Mo-V Creep Resistant Steels for Elevated Temperature and Corrosive Service.

Classifications:

AS/NZS 1167.2: RB3.
AWS/ASME-SFA A5.28: ER90S-B3.

Packaging Data:

| Rod Size (mm) | Pack Weight/Type | Approx. Rods/kg | Part No |
|---------------|------------------|-----------------|---------|
| 2.4 x 1,000 | 5kg Tube* | 29 | 321383 |

* Resealable

COMWELD 308L



WELD DEPOSIT PROPERTIES:

| | |
|--------------------------------------|--|
| Typical Weld Metal 0.2% Proof Stress | |
| 450 MPa. | |
| Typical Weld Metal Tensile Strength | |
| 600 MPa. | |
| Approximate Melting Point | |
| 1400°C | |
| Weld Metal Density | |
| 7.95 gms / cm ³ | |
| All Weld Metal Microstructure | |
| Austenite with 5 – 8 % ferrite | |

TYPICAL ROD ANALYSIS:

| | | |
|------------|-------------|-----------|
| C: 0.015% | Mn: 1.90% | Si: 0.50% |
| Cr: 19.90% | Ni: 9.75% | P: 0.020% |
| S: 0.005% | Fe: Balance | |

COMPARABLE CIGWELD PRODUCTS:

Satinchrome 308L-17 electrode
AWS A5.4: E308L-17
Murex Speedex 308L
AWS A5.4: E308L-18
Autocraft 308LSi GMAW wire
AWS A5.9: ER308LSi
Shieldchrome 308LT FCAW wires
AWS A5.22: E308LT-1-1/4

- ▲ Resealable 5kg Plastic Tube.
- ▲ Suitable for Gas and GTA (TIG) Welding.
- ▲ End Stamped with AS / AWS Class '308L'.
- ▲ DARK BLUE COLOUR CODED Label for Instant I.D.

Classifications:

AS/NZS 1167.2: R308L.
AWS/ASME-SFA A5.9: ER308L.

Packaging Data:

| Rod Size (mm) | Pack Weight/Type | Approximate Rods/kg | Part No |
|---------------|------------------|---------------------|---------|
| 1.6 x 914 | 5kg Tube* | 69 | 321406 |
| 2.4 x 914 | 5kg Tube* | 30 | 321407 |

* Resealable

COMWELD 309L



WELD DEPOSIT PROPERTIES:

| | |
|--------------------------------------|--|
| Typical Weld Metal 0.2% Proof Stress | |
| 440 MPa. | |
| Typical Weld Metal Tensile Strength | |
| 590 MPa. | |
| Approximate Melting Point | |
| 1400°C | |
| Weld Metal Density | |
| 7.95 gms / cm ³ | |
| All Weld Metal Microstructure | |
| Austenite with 15 – 20 % ferrite | |

TYPICAL ROD ANALYSIS:

| | | |
|-----------|-------------|-----------|
| C: 0.015% | Mn: 1.90% | Si: 0.45% |
| Cr: 23.5% | Ni: 13.5% | P: 0.020% |
| S: 0.005% | Fe: Balance | |

COMPARABLE CIGWELD PRODUCTS:

Satinchrome 309Mo-17 electrode
AWS A5.4: E309Mo-17
Murex Speedex 309L
AWS A5. 4: E309L-16
Autocraft 309LSi GMAW wire
AWS A5.9: ER309LSi
Shieldchrome 309LT FCAW wires
AWS A5.22: E309LT1-1/4

- ▲ Resealable 5kg Plastic Tube.
- ▲ Suitable for Gas and GTA (TIG) Welding of highly alloyed 309 or 309L type stainless steel.
- ▲ End Stamped with AS / AWS Class '309L'.
- ▲ RED COLOUR CODED Pack Label for Instant I.D.
- ▲ Also suitable for the dissimilar joining of other 300 series austenitic stainless steels to ferritic steels.

Classifications:

AS/NZS 1167.2: R309L.
AWS/ASME-SFA A5.9: ER309L.

Packaging Data:

| Rod Size (mm) | Pack Weight/Type | Approximate Rods/kg | Part No |
|---------------|------------------|---------------------|---------|
| 1.6 x 914 | 5kg Tube* | 69 | 321403 |
| 2.4 x 914 | 5kg Tube* | 30 | 321404 |

* Resealable