

ESAB CHROMWELD G

ESAB CHROMWELD G is a rutile coated stainless steel electrode depositing an 18Cr-8Ni-5Mn work hardening type weld metal. The electrode is specially designed for applications involving good work hardening properties and for joining of high tensile steels.

Welding Current	AC, DC+
Alloy Type	Austenitic Cr-Ni-Mn
Coating Type	Rutile

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	470 MPa	630 MPa	38 %

Typical Weld Metal Analysis %						
C	Mn	Si	Ni	Cr	Mo	Cu
0.06	4.50	0.80	8.20	18.40	0.30	0.04

Deposition Data	
Diameter	Current
2.5 x 350.0 mm	60-100 A
3.15 x 350.0 mm	80-120 A
4.0 x 350.0 mm	120-170 A