

# ESAB CHROMWELD G (Spl)

A high alloyed Electrodes for high strength applications



## DESCRIPTION

ESAB Chromweld G Special is a lime rutile coated stainless steel electrode depositing high strength 20 Cr - 8.5 Ni - 6 Mn - 0.6 Mo type work hardening austenitic weld deposit. The Electrode is especially suitable for high impact and corrosion resistance combined with moderate abrasion at elevated temperature. The design ensures excellent running performance with smooth stable arc with good wetting action and minimum spatter level. The weldmetal is designed to have optimum ferrite content to prevent hot cracking and suitable for welding of dissimilar steels and high tensile steels.

**WELDING CURRENT:** DC +, AC 70V

## TYPICAL APPLICATIONS

ESAB Chromweld G Special is designed for welding of high strength alloy steel and dissimilar joints. The unique composition enables this electrode to be most suitable for welding of Gun Carriage base plates, High Tensile Armour Plates, joining of austenitic manganese steel components, etc.

## TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.06	Cr	20.0	UTS	640 N/mm <sup>2</sup>
Mn	5.53	Mo	0.6	EL (L=4d)	40%
Si	0.6			CVN (RT)	9 kgfm
Ni	10.5			Impact (CVN) at RT	90 J

## CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	70-100	80	400
3.15	350	90-115	60	300
4.00	350	110-170	40	200
5.00	350	140-200	30	150

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