AS DA-771

Coated Electrode for High Strength Low Alloyed Steels

Classification

EN ISO 3580 : (E CrMo 1 R 12)
AWS A5.5 : (E8013-B2)

General Description

AS DA-771 is a rutile coated electrode. It gives a Cr-Mo alloyed weld metal that is used in the welding of creep resistant pressure vessels and pipe steels operating under high temperatures. AS DA-771 is especially used for 13 CrMo 44 type steels that are frequently used in operating temperatures up to 570°C. It gives a root pass free of porosity with a minimum amount of spatter.

Chemical Composition (w%), Typical, All Weld Metal

C	Si	Mn	Cr	Mo
0.06	0.30	0.80	1.20	0.40

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 520 N/mm²
Tensile Strength : 600 N/mm²
Elongation (L=5d) : 22 %
Impact (ISO-V) : 60 J (+20°C)

Approvals

GOST, SEPRO, TSE

Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : AC min 50 V ; DC (–)

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
2.50	350	70 - 95	2200	3.3 / 150	5
3.25	350	100 - 140	3050	4.1 / 135	5

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Applications and Materials to be Welded

AS DA-771 is used for the welding of vapor pipes and boiler and pressure vessels that are manufactured from Cr-Mo steels. AS DA-774, a basic coated electrode, should be preferred in the multi-pass welding of thick sectioned and rigidly restrained mass structures.

	DIN	EN	Werkstoff Nr.
Heat Resistant Steels	15 CrMo 5	–	1.7205
	–	25CrMo4	1.7218
	–	42CrMo4 *	1.7225
	24 CrMo 5	–	1.7258
	13 CrMo 4 4	13CrMo4-5	1.7335
	22 CrMo 4 4	–	1.7350
	16 CrMoV 4	–	1.7728
Cast Steels	GS-25 CrMo 4	G25CrMo4	1.7218
	GS-22 CrMo 5 4	G22CrMo5-4	1.7354
	GS-17 CrMo 5 5	G17CrMo5-5	1.7357

(*) Mechanical properties should be considered.