

Coated Electrode for High Strength Low Alloyed Steels

Classification

EN ISO 3580 : E CrMo 2 B 22
AWS A5.5 : E9018-B3

General Description

AS DA-777 is a basic coated electrode for joining and welding of heat and creep resistant steels containing 2.2% Cr + 1% Mo that are exposed to operating temperatures up to 600°C. The weld metal has a high resistance to cracking. AS DA-777 runs with a quite, stable arc giving a minimum amount of spatter and smooth weld beads. It is recommended to use the electrode in DC (+).

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

C	Si	Mn	Cr	Mo
0.05	0.40	0.80	2.40	1.10

Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 560 N/mm ²
Tensile Strength	: 650 N/mm ²
Elongation (L=5d)	: 22 %
Impact (ISO-V)	: 80 J (+20°C)

Approvals

GOST, SEPRO, TSE

Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : 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	80 - 110	2160	4.3 / 200	5
3.25	350	90 - 140	3420	4.8 / 140	5
4.00	450	130 - 190	6450	6.4 / 100	6
5.00	450	150 - 240	10000	6.0 / 60	6



1G/PA



2F/PB



2G/PC



4G/PE



3G/PF

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Applications and Materials to be Welded

Power plant constructions; flange pipes used in petrochemical plants; forged cast parts, vapor production plants, preheaters and heaters, boiler and pressure vessels and pipe connections are among some application areas where AS DA-777 is used. It can also be used in welding similarly alloyed cementation steels, heat treatable steels and cast steels. Part should be preheated before welding to avoid the cracking risk and operating temperature during welding should not exceed 300°C.

	<u>DIN</u>	<u>EN</u>	<u>Werkstoff Nr.</u>
Heat Resistant Steels	26 CrMo 7	–	1.7259
	24 CrMo 10	–	1.7273
	10 CrMo 11	–	1.7276
	16 CrMo 9 3	–	1.7281
	12 CrMo 9 10	–	1.7375
	–	10 CrMo 9-10	1.7380
	10 CrSiMoV 7	–	1.8075
Cast Steels	GS-18 CrMo 9 10	G17 CrMo 9-10	1.7379