

welding with weave method.

3. Dry the electrodes at 250~300°C for 60 minutes before using. Take out consumables for half day consumption and keep in the environment at 100~150°C during welding process.
4. Use lower current to prevent from cracking and minimize base metal dilution.
5. Pre-heat at 100-150°C, and post-weld heat treatment at 620°C or lower.

Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S	Cr	Ni	Mo	Cu
0.03	0.2	0.35	0.03	0.010	12.0	4.5	0.50	0.04

Typical mechanical properties of weld metal:

Tensile strength MPa(ksi)	Elongation %	PWHT
970(141)	18	