

## Applications

SR-133 is designed for welding of Inconel 600 and 601, Incoloy 800 and 800HT dissimilar welding of stainless steels and low-alloyed steel & Nickel-alloyed steel.(Inconel, Incoloy, Monel alloys) It can be used for welding of overlay cladding where a similar composition.

## Characteristics on Usage

SR-133 has High impact toughness at low temperature -196°C(-321°F), excellent arc & slag stability and hot cracking resistance. It provides Better productivity(anti-heat feature).

## Notes on Usage

- ① Remove rust, Scales, Oil, Paint, Slag of tack welds.
- ② Keep the arc as short as possible.
- ③ Dry the electrode at 300~350°C(572~662°F) for 60 minutes before use.
- ④ Keep the welding current as low as possible.

## Welding Position



1G 2F 3G 4G  
 (PA) (PB) (PF) (PE)

## Current

AC or DC +

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Nb+Ta	Fe	Cu	Others
0.05	0.15	3.10	0.005	0.003	15.0	71.5	1.0	1.25	7.5	0.01	-

## Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
610 (88,500)	37	-196 (-321)	90 (66)

## Approval

## I Packing

Packet 5 kg (11 lbs)  
 Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	350 (14)	350 (14)	350 (14)
F	100 - 105	120 - 140	140 - 180
V-up, OH	100 - 105	110 - 115	110 - 130