

Applications

SR-134 is designed for welding of 9%Ni steel for cryogenic storage tanks for LNG, liquified nitrogen, etc.

Characteristics on Usage

SR-134 is an Inconel type electrode and weld metal shows excellent strength and toughness at cryogenic temperatures. With AC, it permits easy operation free from arc blow.

Notes on Usage

- ① Remove rust, scales, oil, paint, slag of tack welds.
- ② Keep the arc as short as possible.
- ③ Dry the electrodes at 350~450°C (662~842°F) for 60 minutes before use.
- ④ Keep the welding current as low as possible.

Welding Position

Current



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

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Nb	Fe
0.12	0.40	2.80	0.003	0.001	15.3	70.0	3.1	2.35	5.40

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
715 (103,700)	40	-196 (-321)	60 (44)

Approval

I Packing

Packet 2.5 kg (5.5 lbs)
Carton 2.5 kg (5.5 lbs) × 4 : 10kg(22 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	70 - 115	95 - 150	140 - 180
V-up, OH	65 - 110	85 - 135	110 - 140