

Applications

SR-08 is designed for welding of 9%Ni steel for tack and repair welding.

Characteristics on Usage

SR-08 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



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

Current

AC

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo	W	Fe
0.04	0.30	0.30	0.003	0.001	2.85	68.6	17.9	3.05	6.45

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
760 (110,000)	40	-196 (-321)	75 (55)

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)
Length mm(in)	350 (14)	350 (14)
F	70 - 115	95 - 150
V-up, OH	65 - 110	85 - 135