

SA P-24

CATEGORY SAW Arc Submerged

TYPE Vacume melted, medium alloyed, Creep resistant alloy for sub arc welding.

APPLICATIONS High temperature and creep resistant boilers, pipe work etc..

PROPERTIES Remarkable creep resistant micro alloy controlled alloy developed to offer high strenght and creep resistant properties at elevated temperatures. Combined with flux FL 155 excelent slag release will be obtained in single and multirun application, the neutral action of the flux offers reliable chemical annalysys to ensure the best possible creep properties.

CLASSIFICATION EN ISO S Z CrW2

SUITABLE FOR Creep resistant steels , 7CrMoVTiB, P24/T24, ASTM A213, pipe steel, P24/T24, ASTM A213

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS % WITH FL 155

C	Mn	Si	Cr	Nb	Mo	V	B
0.075	0.8	0.06	2.3	0.035	1.0	0.15	0.002

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V (J)
SR	520	620	15	100

SR: stress relieved at 740°Celsius for 2 hours

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing	
	Voltage (V)	Current (A)	Spool type	kg / spool
2.0			Coil / K-415	25
2.4			Coil / K-415	25
3.2			Coil / K-415	25

REDRYING TEMPERATURE not required