

Base Material:	SA-240 Gr. 329	to:	SA-240 Gr. 329
Alloy Designation:	S32900		S32900
Principal Composition:	26Cr-4Ni-Mo		26Cr-4Ni-Mo
P-Number:	10H		10H
Group No.:	1		1
Preheat Temperature:	10 C (50 F)		
Filler Wire (GTAW):	ER2553		
F-Number:	6		
A-Number:	8		
AWS:	5-9		
Interpass temperature:	150 C (300 F) max.		
Electrode (SMAW):	E2553-16 /-15		
F-Number:	5		
A-Number:	8		
AWS:	5-4		
Postweld Heat Treatment:	None		
General Comments:			