

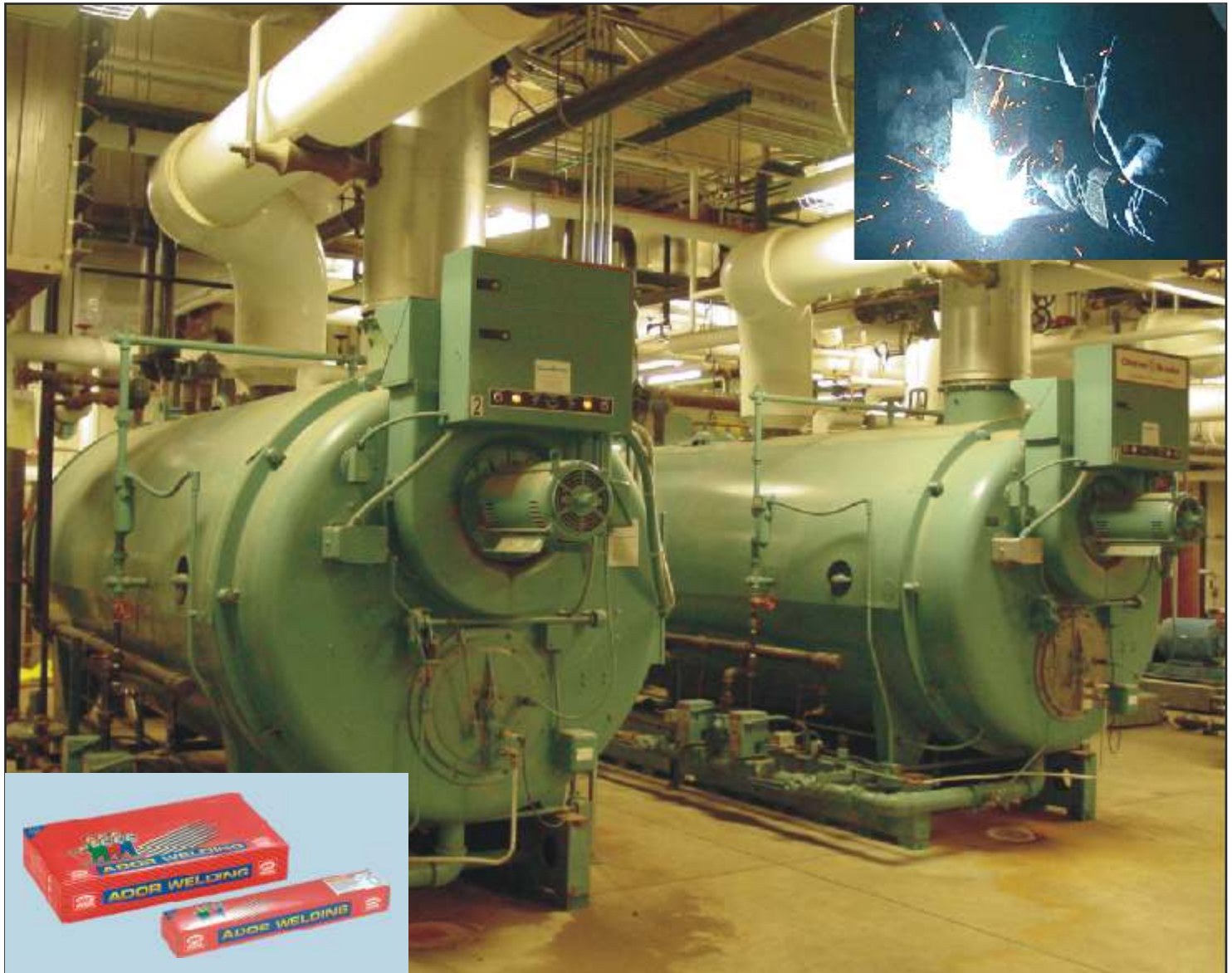
CROMOTEN SERIES

CROMOTEN

CROMOTEN C

CROMOTEN SPL

For Refineries, Power plants, Chemical plants, Pressure vessels, Boilers.



- A low Hydrogen, Iron Powder Electrodes.
- Electrodes gives excellent arc stability, arc smoothness and easy slag removed with negligible spatter.
- Weld metal is of X-Ray quality.



ADOR WELDING LIMITED
Central Marketing Office

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CROMOTEN SERIES

CROMOTEN CROMOTEN C CROMOTEN SPL

For Refineries, Power plants, Chemical plants, Pressure vessels, Boilers.

CROMOTEN

CLASSIFICATIONS

AWS A/SFA 5.5 E 8018-B2
IS 1395 E 55 BB 226 Fe

EN 1599 E CrMo 1B42 H10
DIN 8575 E CrMo 1B 20+

COATING TYPE: Basic
COATING FACTOR: Heavy

DEPOSITION EFF., %: ~110
IDENTIFICATION: Brand Printed

CHARACTERISTICS

A low-hydrogen, iron-powder electrode. For welding of 1.25% Cr-0.50% Mo creep resistant steels. Weld metal is creep and heat resistant upto 550°C. It gives excellent arc stability, arc smoothness and very easy slag removal. Weld metal is X-ray quality.

TYPICAL APPLICATIONS

Welding of 1.25%Cr-0.50% Mo steels used in Refineries, Power plants, Chemical plants, Pressure vessels, Boilers. Suitable for joining P4 materials e.g. F2, F11, F12 grades of SA-182/182M; T11 and T12 grades of SA-213/213M; P11, P12 grades of SA-335/335M; 2,11,12 grades of SA-387/387M etc.

WELD METAL CHEMISTRY, wt%

C - 0.05-0.09 Cr - 1.0-1.50 P - 0.030 max. Mo - 0.40-0.65 S - 0.030 max. Mn - 0.50-0.90 Si - 0.25-0.60 Diffusible H₂ Content ml/100gm <5

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	% Elong.	CVN Impacts,J	Hardness,
	MPa	MPa	(L=4xd)	27°C	BHN
PWHT	560-680	470-600	22-28	50-100	225 max.

PWHT: Post weld heat treated at 690°C for 1 hr

APPROVALS

ABS E 8018-B2 NPCIL E 8018-B2
IBR E 8018-B2 Toyo E 8018-B2

KRL E 8018-B2

CURRENT CONDITIONS: AC (70V), DC (+)

5.0	4.0	3.2	2.5
190-	140-	100-	60-
250	180	140	90

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS 300°C for 1 Hr
(Optionally also available in vacuum-packed condition, redrying not required in this packaging)

PACKING DATA

Dia.,mm	5.0	4.0	3.2	2.5
Length,mm	450	450	450	350
Wt. per carton, kgs	5.25	5.25	5.25	5.25
Cartons/ box	4	4	4	4
Wt. per box, kgs	21	21	21	21

CROMOTEN C

CLASSIFICATIONS

AWS A/SFA 5.5 E9018-B3
IS 1395 E 53 BB 326 Fe
DIN 8575 E CrMo 2 B26

COATING TYPE: Basic
COATING FACTOR: Heavy

DEPOSITION EFF., %: ~110
IDENTIFICATION: Brand Printed

CHARACTERISTICS

An electrode for welding of 2.25%Cr-1.0% Mo creep resistant steels. Weld metal is creep and heat resistant upto 600°C. It gives excellent arc stability, arc smoothness and very easy slag removal. Weld metal is of X-ray quality.

TYPICAL APPLICATIONS

Welding of 2.25%Cr-0.50%Mo and 2.25%Cr-1.0%Mo steels used in Refineries, Power plants, Chemical plants, Pressure vessels, Boilers. Suitable for joining P5A materials e.g. F22 grade of SA-182/182M; T22 grade of SA-213/213M; P22 grade of SA-335/335M; 22 grade of SA-387/387M etc. German steels e.g. 12 CrMo 9 10, 10 CrSiMoV7.

WELD METAL CHEMISTRY, wt%

C - 0.05-0.09 Mn - 0.45-0.75 Si - 0.20 - 0.65 S - 0.030 max. P - 0.030 max. Mo - 0.90-1.25 Cr - 2.0-2.50

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	% Elong.	CVN Impacts,J	Hardness,
	MPa	MPa	(L=4xd)	27°C	BHN
PWHT	625-740	540-640	20-24	100-160	225 max.

PWHT: Post weld heat treated at 690°C for 1 hr

APPROVALS

IBR E9018-B3

CURRENT CONDITIONS: AC(70V), DC (+)

5.0	4.0	3.2	2.5
190-	140-	100-	60-
250	180	140	90

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 1 hour

PACKING DATA

Dia.,mm	5.0	4.0	3.2	2.5
Length,mm	450	450	450	350
Wt. per carton, kgs	5.25	5.25	5.25	5.25
Cartons/ box	4	4	4	4
Wt. per box, kgs	21	21	21	21

CROMOTEN (Spl)

CLASSIFICATIONS

AWS A/SFA 5.5 E 7018 B2L IS 1395 E 63 RB 325

COATING TYPE: Basic

DEPOSITION EFF., %: ~110

COATING FACTOR: Heavy

IDENTIFICATION: Brand Printed

CHARACTERISTICS

An electrode for welding of 1.25% Cr-0.50% Mo creep resistant steels. Weld metal is creep and heat resistant upto 600°C. It gives excellent arc stability, arc smoothness and very easy slag removal. Weld metal is X-ray quality.

TYPICAL APPLICATIONS

Welding of 1.25%Cr-0.50% Mo steels used in Refineries, Power plants, Chemical plants, Pressure vessels, Boilers. Suitable for joining P5A materials e.g. F22 grade of SA-182/182M; T22 grade of SA-213/213M; P22 grade of SA-335/335M; 22 grade of SA-387/387M etc. German steels e.g. 12 CrMo 9 10, 10 CrSiMoV7.

WELD METAL CHEMISTRY, wt%

C - 0.05 max. Mn - 0.45-0.75 Si - 0.20-0.45 S - 0.030 max. P - 0.030 max. Mo - 0.40-0.65 Cr - 1.0-1.50

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	% Elong.	CVN IMPACT, J
	MPa	MPa %	(L=4Xd)	-18°C
PWHT	625-740	540-640	20-24	50-100

PWHT: Post weld heat treated at 690°C for 1 hr

CURRENT CONDITIONS: AC, DC (+)

5.0	4.0	3.2	2.5
190-	140-	100-	60-
250	180	140	90

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 1 hour

PACKING DATA

Dia.,mm	5.0	4.0	3.2	2.5
Length,mm	450	450	450	350
Wt. per carton, kgs	5.25	5.25	5.25	5.25
Cartons/ box	4	4	4	4
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