

CROMOTEN 9

CLASSIFICATIONS

AWS/SFA 5.5

E 8018-B8

BS 2493

E 9CrMoBH

DIN 8575

E CrMo9B26

DEPOSITION EFF., %: ~ 110

IDENTIFICATION: Brand Printed

CHARACTERISTICS

A heavy coated basic type electrode specially designed for welding of ferritic martensitic chrome steels. The weld deposit, which contain approx. 9% Cr is air hardenable and therefore calls for suitable preheat and postheat treatment. Weld deposits are of radiographic quality. Redry electrodes at 300°C one hour for better results.

TYPICAL APPLICATIONS

For welding 9% Cr plates, pipes and tubes

For general corrosion and heat resistance applications.

Forging:

ASTM A336 Grade F9

Pipes:

ASTM A335 Grade P9

Tubes:

ASTM A199 Grade T9

ASTM A213 Grade T9

Castings:

ASTM A 217 C 12

CURRENT CONDITIONS: AC, DC (+)

4.0	3.2	2.5
140-	100-	60-
180	140	90

WELDING POSITIONS

F, H, V -up, OH

REDRYING CONDITIONS

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

MECHANICAL PROPERTIES-ALL-WELD (PWHT 740+10 °C/1 hr)

UTS	YS	% Elong.
MPa	MPa	(L=4xd)
550-650	460-540	19-26

WELD METAL CHEMISTRY, wt%

C - 0.05-0.10	Mo - 0.85-1.20	Cr. - 8.0-10.0
Mn - 0.50-1.00	S - 0.025 max.	
Si - 0.20-0.70	P - 0.025 max.	
Diffusible H ₂ content ml / 100gm < 5		

PACKING DATA

Dia.,mm	4.0	3.20	2.5
Length,mm	350	350	350
Wt. per carton, kgs	5.0	5.0	5.0
Cartons/ box	4	4	4
Wt. per box, kgs	20	20	20