

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 **DEPOSITION EFF., %:** ~110
COATING FACTOR: Heavy **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.

APPROVALS

IBR E9018-B3

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

5.0	4.0	3.2
190-	140-	100-
250	180	140

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 1 hour

MECHANICAL PROPERTIES- ALL-WELD

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

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

WELD METAL CHEMISTRY, wt%

C - 0.05-0.09 S - 0.030 max. Cr - 2.0-2.50
Mn - 0.45-0.75 P - 0.030 max.
Si - 0.20 - 0.65 Mo - 0.90-1.25
Diffusible H₂ content ml / 100gm < 5

PACKING DATA

	5.0	4.0	3.2
Dia.,mm	450	450	450
Length,mm	5.0	5.0	5.0
Wt. per carton, kgs	4	4	4
Cartons/ box	20	20	20
Wt. per box, kgs			

Related Products: Tigfil-90SG, Tigfil-90SB3, Cromoten-C Spl, Cromoten-2STC, Automig FC 91T1-B3



ADOR WELDING LIMITED

