CROMOTEN C (PHT Batch)

CLASSIFICATIONS

AWS/SFA 5.5	E 9018 B3
BS 2493	E 2CrMoBH
IS 1395	E 538B3-26 Fe
DIN 8575	E CrMo 2B26

COATING TYPE : Basic **IDENTIFICATION:** Brand Printed

CHARACTERISTICS

A medium-heavy coated, hydrogen-controlled iron powder type, all position electrode with deposition efficiency of approx. 106% giving low alloy steel weld metal having approx 2.25% Cr-1.0% Mo. Welds are radiographically sound, creep resistant upto 600^{0}C. After PWHT, the weld metal also gives very good impact resistance.

CURRENT CONDITIONS:

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

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300^{0}C-1 hour

TYPICAL APPLICATIONS

Alloy cast steel grade GS 17CrMo55, GS 18 CrMo910. Low alloy steel boilers and pipings operating at service temperatures upto 600^{0}C in oil refinery, thermal and plant. Repair of high tensile steel castings.

MECHANICAL PROPERTIES- ALL-WELD

UTS MPa	YS MPa	% Elong. (L=4xd)	CVN Impacts, J 0^{0}C
620 min.	530 min.	17-25	40 min.

After PWHT at 710^{0}C for 4 hours

PACKING DATA

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

WELD METAL CHEMISTRY, wt%

C	- 0.10 - 0.15	Mo	- 0.90 - 1.25	Cr	- 2.0-2.50
Mn	- 0.60 - 0.90	S	- 0.025 max.		
Si	- 0.25 - 0.45	P	- 0.025 max.		

Diffusible H_2 content ml / 100gm < 5