

# CROMOTEN C (PHT Batch)

## CLASSIFICATIONS

<b>AWS/SFA 5.5</b>	E 9018 B3
<b>BS 2493</b>	E 2CrMoBH
<b>IS 1395</b>	E 538B3-26 Fe
<b>DIN 8575</b>	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°C. After PWHT, the weld metal also gives very good impact resistance.

## TYPICAL APPLICATIONS

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

## CURRENT CONDITIONS:

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

## WELDING POSITIONS

F, H, V-up, OH

## REDRYING CONDITIONS

300°C-1 hour

### MECHANICAL PROPERTIES- ALL-WELD

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

After PWHT at 710°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<sub>2</sub> content ml / 100gm < 5