

CROMOTEN D

CLASSIFICATIONS

AWS A/SFA 5.5 E 8018-B6
IS 1395 E 41 BB 626 Fe
DIN 8575 E CrMo 5 26

EN 1599 E CrMo 5 B42 H10

COATING TYPE: Basic

DEPOSITION EFF., %: ~110

COATING FACTOR: Heavy

IDENTIFICATION: Brand Printed

CHARACTERISTICS

A low-hydrogen, iron-powder electrode. For welding of 5%Cr-0.5% Mo creep resistant steels. Weld metal is creep and heat resistant upto 650°C. Weld metal is of air-hardenable type, so proper care is required while welding. It gives excellent arc stability, arc smoothness and very easy slag removal. Weld metal is of X-ray quality.

TYPICAL APPLICATIONS

Welding of 5%Cr-0.50% Mo steels used in Refineries, Power plants, Chemical plants, Pressure vessels, Boilers. Suitable for joining P5B materials e.g. F5 grade of SA-336/336M; 5 grade of SA-387/387M, etc.

APPROVALS

DNV E 8018-B6
Toyo E 8018-B6

CURRENT CONDITIONS: AC, 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 (Optionally also available in vacuum-packed condition, redrying not required in this packaging)

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L= 4xd)	CVN Impacts, J +27°C	Hardness, BHN
PWHT	550-650	460-520	20-25	80-140	225 max.

PWHT: Post weld heat treated at 740°C for 1 hr

WELD METAL CHEMISTRY, wt%

C - 0.05 - 0.10	S - 0.030 max.	Diffusible H ₂
Cr - 4.0 - 6.0	Mn - 0.50 - 0.90	Content ml/ 100g
P - 0.030 max.	Si - 0.25 - 0.65	<5
Mo - 0.45 - 0.65		

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

Related Products: Tigfil I-80SB6Cr, Cromoten-D Spl



ADOR WELDING LIMITED

