

# CROMOTEN S PLUS

## CLASSIFICATIONS

**AWS/SFA 5.5** E7018 B2L

**IDENTIFICATIONS:** Brand Printed

## CHARACTERISTICS

A hydrogen-controlled extra low carbon iron powder electrode giving 1.2Cr-0.5 Mo type weld metal. The electrode burns with smooth and stable arc, Low spatter and gives uniform weld bead with easily detachable slag. The deposited weld metal is of radiographic quality and the electrode can be used at all position. The weld metal is resistant to creep up to 500°C and offers impact resistance even at sub-zero temperatures.

## TYPICAL APPLICATIONS

● The electrode is suitable for welding similar composition creep resistant steels used for boilers, power plants, oil refineries, chemical plants, etc. ● Suitable for joining steel conforming to Grade F2 (P. No. -3), F 11 (all classes- P.No.-4), F12 (class 1 & 2- P.No.4) of SA -182/ SA -182M, Grade T 11 (P. No.-4) of SA-199/ SA-199M, Grade T2 (P.No.3), T11 & T 12 (P.No.-4) of SA -213/SA231M, Grade Wc6 of SA-217/ SA 217M, (P. No.4), Grade P2 (P. No.-3), P11 & P12 (P. No.-4) of SA-335/ SA-335M, Grade Fp2 (P. No.-3), FP11 & FP12 (P. No.-4) of SA-369 / SA369M, Grade 2 (P.No.-3), 11 & 12 (P. No.-4) of SA-387 / SA387M, Grade Cp2 (P. No.-3), Cp11 & Cp12 (P.No.-4) of SA-426/SA426m, 13 Cr Mo 44, 15 Cr Mo5, etc. ● The electrode shall be re-dried at 300°C for 1 hour prior to use.

**CURRENT CONDITIONS :** AC (70) / DC (+)

5.0	4.0	3.20
180-220	130-170	100-120

## 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

UTS	YS	% Elong.	CVN impacts, J
MPa	MPa	(L = 4xd)	18°C
520 min	390 min	19 min	50

(After SR at 720°C for 2 hrs, Charpy Impact at -18°C is > 50 Joules)

### WELD METAL CHEMISTRY (%)

C - 0.05 max	Mn - 1.0 max	Si - 0.90 max
Cr - 1.0-1.5	Mo - 0.40-0.65	S - 0.03 max
P - 0.03max.		

Diffusible H<sub>2</sub> content ml / 100gm < 5

### PACKING DATA

Dia, mm	5.00	4.00	3.20
Length, mm	450	450	450
Wt. per carton	5	5	5
Pcs per carton	4	4	4
Pcs Per Box	20	20	20