

CROMOTEN 2 STC

AWS A/SFA 5.5 E9018-B3

LOW ALLOY STEEL (High Temperature)

CLASSIFICATION:

EN ISO 3580-A
E CrMo2 B 32 H5

IS 814

-

KEY FEATURES:

- Non synthetic, basic coated iron powder electrode
- Low alloy steel Cr-Mo deposit
- Resistant to creep and heat upto 600°C
- Ductile and crack resistant and heat treatable weld
- Radiography quality weld metal

APPROVALS: ABS/IBR/NPCIL

TYPICAL APPLICATIONS:

- Welding of 2.25Cr-0.5Mo and 2.25Cr-1Mo type creep resistant steels
- Cr-Mo and Cr-Mo-V bearing steels for high temperature applications
- Main steam pipes of boilers in electric power plant, Boiler super heaters
- Joining of P5A materials
- Suitable for 12CrMo9-10, 10CrSiMoV7 German steels
- Joining ASTM A 335 Gr.P22, A 387 Gr.22 materials
- Application in refineries, power plants, pressure vessels, boilers

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


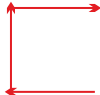
C	Mn	Si
0.08	0.6	0.4

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Typical	PWHT: 690°C for 1 hr.	660	580	22	100
Specification		620 min	530 min	17 min	40 min

Hardness, 3 Layer: 180-200 BHN **Diffusible H2 Content:** <5 ml/100 gm **Special Tests:** -

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	60-90	 AC (70 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions 
3.15 x 350	100-140		
4.0 x 450	140-180		
5.0 x 450	190-250		

Available in Standard carton packing of 20 kg box containing 4 cartons each. Also available in vacuum packing

EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Automig 70 S - 3	Tigfil 70 S - 2 SPL	Automig FC 71 T - 5	Automelt B20 Plus	Automelt EH 12K
Automig 70 S - 6 (Ar - CO2)	Tigfil 70 - 3		Automelt B41	Automelt EH 10K
	Tigfil 70 S - 6		Automelt B41	Automelt EH 14K



ADOR WELDING LIMITED

www.adorwelding.com