



CROMOTEN 2 STC

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E9018-B3**

CLASSIFICATION:

EN ISO 3580-A
E CrMo2 B 32 H5

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: CE

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	Cr	Mo
0.08	0.6	0.4	2.25	1.0

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -18°C, J
Typical	PWHT: 690°C for 1 hr.	660	580	22	70
Specification		620 min	530 min	17 min	-


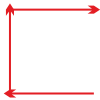
Hardness, 3 Layer: 220 BHN max

X factor = (10P + 5Sb + 4Sn + As)/100 < 15ppm

Diffusible H2 Content: < 5 ml/100 gm

Special Tests: Creep Rupture Test at 550°C - 160 MPa, stress for min. 1000 hrs

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	50-80	 AC (70 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15 x 450	90-130		
4.0 x 450	130-170		
5.0 x 450	180-240		

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

EQUIVALENT:

GTAW	SAW	
	Flux	Wire
Tigfil 90S-B3 SPL	Automelt B20 Plus	Automelt EB3R