



CROMOTEN 9

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E8018-B8**

CLASSIFICATION:

EN ISO 3580-A
E CrMo9 B 32 H5

IS 1395
E41B-B8

KEY FEATURES:

- Basic type heavy coating
- 1 Mo type low alloy weld deposit
- Resistant to corrosion and hydrogen attack at high temperatures
- Air hardenable alloy
- Optimum combination of strength, toughness with heat resistance
- Radiographic quality weld deposit
- Positional welding capability

APPROVALS: CE

TYPICAL APPLICATIONS:

- Suitable for welding of 9% Cr type P5B materials in forging, pipes, tubes and casting form
- Welding of ferritic martensitic chrome steels
- For general corrosion and heat resistance application
- Application in Power plants, Oil refineries, Chemical and Petrochemical industries

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


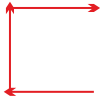
C	Mn	Si	Cr	Mo
0.06	0.6	0.2	8.7	0.9

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	PWHT: 740°C for 1 hr.	605	495	22
Specification		550 min	460 min	19 min

Diffusible H2 Content: <5 ml/100 gm

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, except vertical Down 
3.15 x 350	100-140		
4.0 x 350	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
Automig 80S-B8	Tigfil-80S-B8