

# CROMOTEN C S PLUS

AWS A/SFA 5.5 E8018-B3L

LOW ALLOY STEEL (High Temperature)

## CLASSIFICATION:

EN ISO 3580-A  
E CrMo2L B 12 H5

IS 1395  
E63 B-B3L

## KEY FEATURES:

- Basic coated electrode
- Low carbon Cr-Mo type deposit
- Weld metal is creep & heat resistant upto 600°C
- Weld deposit is highly resistant to cracking
- Heat treatable weld deposit
- Radiographic quality weld

**APPROVALS:** CE

## TYPICAL APPLICATIONS:

- Best suited for joining 2.25 Cr-1 Mo creep resistant steels used in refineries, power plants, chemical plants, Pressure vessels and boilers
- Joining of P5A materials like SA 182/182M Gr.F22, German steels 12CrMo9-10, 10CrMo9-10, 10CrSiMoV7

## TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:



C	Mn	Si	Cr	Mo
0.04	0.75	0.45	2.3	1.1

## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	PWHT: 690°C for 1 hr.	600	525	20
Specification		550 min	460 min	17 min

**Diffusible H2 Content:** <5 ml/100 gm

## PARAMETERS - PACKING DATA:

<b>Ø x L, mm</b> 2.5 x 350 3.15 x 350 4.0 x 450 5.0 x 450	<b>Amperage, A</b> 60-90 100-140 140-180 190-250	 <b>AC (70 OCV)/DCEP</b>  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
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Available in Standard carton packing of 20 kg box containing 4 cartons each. Also available in vacuum packing

## EQUIVALENT:

GMAW	GTAW
Automig 80S-B3L	Tigfil 80S-B3L