



# CROMOTEN C S PLUS

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 E8018-B3L

### 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 %:


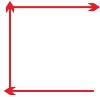
C	Mn	Si	Cr	Mo
0.04	0.75	0.45	2.3	1.1

### 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:

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

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