



CROMOTEN C S PLUS

LOW ALLOY STEEL (High Temperature)



Low Carbon Cr-Mo Type Creep Resistant Steel Electrode

CLASSIFICATION : EN ISO 3580-A

AWS A/SFA 5.5

E CrMo2L B 12 H5

E 8018-B3L

KEY FEATURES :

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

WELDING POSITION :



AC (70 OCV)/DCEP

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

REDRYING CONDITION : 250-300°C for minimum 1 hr. (Also available in vacuum packed condition)

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Mo	S	P
Typical	0.03	0.5	0.4	2.2	1.0	0.008	0.01
Specification	0.05 max	0.9 max	0.8 max	2.0-2.5	0.9-1.2	0.03 max	0.03 max

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

Hardness, 3 Layer: 225 BHN max

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
2.5 x 350	60-90	225	4	22
3.15 x 450	100-140	118	4	42
4.0 x 450	140-180	78	4	64
5.0 x 450	190-250	53	4	94