



CROMOTEN C Ti

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 E9013-G

CLASSIFICATION:

EN ISO 3580-A
E CrMo2 R 12

KEY FEATURES:

- Rutile type coating
- Typical 2.25Cr-1Mo weld deposit
- High strength weld with resistance to creep upto 500°C
- Deposit is heat treatable and case hardenable
- Radiographic quality weld
- Resistant to alkaline solutionsder long term stresses
- Resist strain, corrosion and oxidation
- Preheating and PWHT of basematerials is necessary
- Best suited for root run welding of pipes in all position

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of 2.25Cr-1Mo for boilers and piping operating at service temperatures upto 500°C
- Joining P5A materials e.g. SA-182 Gr.F22, SA-213 Gr.T22, SA-335 Gr.P22 and similar steels
- For welding DIN 10CrMo9-10, 12CrMo9-10, 10CrSiMoV7 steel
- Thermal and chemical plants, Oil refineries
- Welding high-strength joints on tempered steels

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


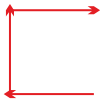
C	Mn	Si	Cr	Mo
0.1	0.6	0.4	2.2	1.1

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	PWHT: 690°C for 1 hr.	675	590	19
Specification		620 min	530 min	14 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: 100°C for ½ hr.	All Positions, except vertical Down 
3.15 x 450	100-140		
4.0 x 450	140-180		
5.0 x 450	190-240		

Available in Standard carton packing of 20 kg box containing 4 cartons 5 kg each. Also available in vacuum packing