ador
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CROMOTEN C Ti

LOW ALLOY STEEL (High Temperature)

Rutile coated electrode for 2.25 Cr–1 Mo type creep resistant steel welding.

CLASSIFICATION : **EN ISO 3580-A** E CrMo2 R 12 **AWS A/SFA 5.5** E 9013-G

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
- Resistant to alkaline solutions
- Preheating and PWHT of base materials is necessary
- Best suited for root run welding of pipes in all position
- Radiographic quality weld

WELDING POSITION : 

AC (70 OCV)/DCEN

TYPICAL APPLICATIONS :

- Welding of 2.25Cr-0.5Mo and 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

REDRYING CONDITION : 100°C for ½ hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Mo	S	P
Typical	0.07	0.5	0.4	2.2	1.1	0.02	0.02
Specification	0.05-0.09	0.45-0.75	0.20-0.45	2.0-2.50	0.90-1.25	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.	675	590	23
Specification		625-740	540-640	20-24

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	240	4	21
3.15 x 450	100-140	115	4	43
4.0 x 450	140-180	74	4	68
5.0 x 450	190-240	45	4	111