

CROMOTEN D

AWS A/SFA 5.5 **E8018-B6**

LOW ALLOY STEEL (High Temperature)

CLASSIFICATION:

EN ISO 3580-A
E CrMo5 B 32 H5

IS 1395
E 41 R-B6

KEY FEATURES:

- Basic type iron powder electrode
- Low carbon 5 Cr-0.5 Mo type weld
- Weld deposit highly resistant to creep and heat upto 650°C
- Air hardenable weld
- Preheat and interpass should be maintained during welding
- All position capability

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of 5 Cr-0.5 Mo creep resistant steels and equivalent grades
- Application in refineries, chemical and power plants, pressure vessels, boiler
- Joining P5B materials e.g. SA 336/336M Gr.F5, SA 387/387MGr.5

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:



C	Mn	Si	Cr	Mo
0.06	0.8	0.3	4.75	0.6

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at 27°C, J
Typical	PWHT: 740°C for 1 hr.	610	490	22	70
Specification		550 min	460 min	19 min	50 min

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm 2.5 x 350 3.15 x 350 4.0 x 450 5.0 x 450	Amperage, A 60-90 100-140 140-180 190-250	 AC (70 OCV)/DCEP REDRYING CONDITION: 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	SAW	
		Flux	Wire
Automig 80S-B6	Tigfil-80S-B6	Automelt B20 Plus	Automelt EB6