

CROMOTEN D S PLUS

AWS A/SFA 5.5 E8018-B6L

LOW ALLOY STEEL (High Temperature)

CLASSIFICATION:

EN ISO 3580-A
E CrMo5L B 32 H5

KEY FEATURES:

- Basic coated electrode
- Low carbon 5 Cr-0.5 Mo type weld
- An air-hardening material and require preheat and interpass temperatures of 175°C minimum during welding
- Excellent creep resistance upto 650°C
- Resistant to oxidation, heat, corrosion and wear
- All position capability

APPROVALS: - CE

TYPICAL APPLICATIONS:

- Welding of 5 Cr-0.5 Mo creep resistant steels and equivalent steels
- Application in petrochemical, refineries and power plants
- Welding tube, pipe and plate subjected to high temperature service, such as ASTM A213-T5 and A335-P5
- P5B materials and similar steels

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:



| C | Mn | Si | Cr | Mo |
|------|-----|-----|-----|-----|
| 0.04 | 0.8 | 0.5 | 4.5 | 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. | 650 | 580 | 24 | 90 |
| Specification | | 550 min | 460 min | 19 min | 50 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 Downwards |
| 3.15 x 350 | 100-140 | | |
| 4.0 x 450 | 140-180 | | |
| 5.0 x 450 | 190-250 | | |
| | | | |
| | | REDRYING CONDITION: 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