



# CROMOTEN D S PLUS

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 E8018-B6L

### 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 %:


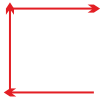
C	Mn	Si	Cr	Mo
0.04	0.8	0.5	4.5	0.6

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	PWHT: 740°C for 1 hr.	650	580	24
Specification		550 min	460 min	19 min

Diffusible H2 Content: <5 ml/100 gm

### PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	60-90	 <b>AC (70 OCV)/DCEP</b>  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	All Positions, except vertical Down  
3.15 x 350	100-140		
4.0 x 450	140-180		
5.0 x 450	190-250		

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