



CROMOTEN D S PLUS

LOW ALLOY STEEL (High Temperature)



Basic coated low carbon 5 Cr-0.5 Mo type Welding Electrode.

CLASSIFICATION : EN ISO 3580-A

AWS A/SFA 5.5

E CrMo5L B 32 H5

E 8018-B6L

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

WELDING POSITION :



AC (70 OCV)/DCEP

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

REDRYING CONDITION : 250-300°C for minimum 1 hr. (Also available in vacuum packed condition)

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr
Typical	0.04	0.7	0.4	4.8
Specification	0.05 max	1.0 max	0.9 max	4.0-6.0
	Mo	Ni	S	P
Typical	0.6	0.1	0.01	0.01
Specification	0.45-0.65	0.40 max	0.03 max	0.03 max

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	108
Specification		550 min	460 min	19 min	80-140

Hardness, 3 Layer: 225 BHN max

Diffusible H2 Content: <5 ml/100 gm

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	238	4	21
3.15 x 450	100-140	106	4	47
4.0 x 450	140-180	79	4	63
5.0 x 450	190-250	53	4	93