CROMOTEN D

LOW ALLOY STEEL (High Temperature)

Low hydrogen basic type Electrode for welding 5 Cr-0.5 Mo steels.

CLASSIFICATION : EN ISO 3580-A	AWS A/SFA 5.5	APPROVALS :
E CrMo5 B 32 H5	E 8018-B6	DNV/IBR

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

WELDING POSITION : 

AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

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

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	0.07	0.8	0.5	5.2
Specification	0.05 - 0.1	1.0 max	0.9 max	4.0-6.0
	Mo	**Ni**	**S**	**P**
Typical	0.5	0.1	0.02	0.02
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.	610	490	22	104
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

EQUIVALENT : GMAW wire: Automig 80S-B6 **GTAW Filler : Tigfil-80S-B6**

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