



CROMOTEN S PLUS

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E7018-B2L**

CLASSIFICATION:

EN ISO 3580-A
E CrMo1L B 32 H5

IS 1395
E 55B-B2L

KEY FEATURES:

- Basic coated electrode
- Typical 1.2Cr-0.5Mo type deposit
- Excellent impact toughness at subzero temperature
- Resist creep upto 500°C
- Crack free and porosity free welds
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Suitable for SA 199/199M Gr.T11, SA 182/182M Gr.F2/F11/F12, SA 213/213M Gr.T2/T11/T12, SA 217/217M Gr.WC6, SA 335/335M Gr.P2/P11/P12 SA 387/387M Gr.2/11/12, 13CrMo44, 15CrMo5
- Suitable for similar composition creep resistant steels used for boilers, oil refineries, chemical and power plants

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Mo
0.03	0.7	0.5	1.2	0.5


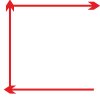
MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	PWHT: 690°C for 1 hr.	570	475	22
Specification		520 min	390 min	19 min

Hardness, 3 Layer: 200 BHN max

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 REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15 x 450	100-120		
4.0 x 450	130-170		
5.0 x 450	180-220		

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kg each. Also available in vacuum packing

EQUIVALENT:

GMAW	GTAW
Automig 70S-B2L	Tigfil 70S-B2L