

CROMOTEN Ti

AWS A/SFA 5.5 E8013-G

LOW ALLOY STEEL (High Temperature)

CLASSIFICATION:

EN ISO 3580-A
E CrMo1 R 12

KEY FEATURES:

- Rutile coated electrode
- Typical 1.2Cr-0.5Mo type low alloy steel deposit
- Resistance to creep upto 500°C
- Especially suited for pipe welding
- All position capability
- Radiographic quality weld deposit

APPROVALS: - CE

TYPICAL APPLICATIONS:

- Welding low alloy steel boilers and piping of Cr-Mo type operating at service temperatures upto 500°C
- Application in oil refineries, thermal & chemical plants
- Suitable for P.No.3 Group No.1 & P.No.4 Group No.1 e.g. SA-182 Gr.F2/F11/F12, SA-199 Gr.T11 and similar steels
- For welding DIN 13CrMo44 steel

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Mo
0.07	0.6	0.3	1.15	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.	625	540	24
Specification		550 min	460 min	16 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	100-130		
4.0 x 450	140-180		
5.0 x 450	190-240		
		REDRYING CONDITION: 100°C for ½ hr..	

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