



## CROMOTEN Ti

LOW ALLOY STEEL (High Temperature)



Rutile coated Electrode for welding of low alloy steel piping.

**CLASSIFICATION : EN ISO 3580-A**

**AWS A/SFA 5.5**

E CrMo1 R 12

E 8013-G

### 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

### WELDING POSITION :



**AC (70 OCV)/DCEN**

### 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

**REDRYING CONDITION : 100°C for ½ hr.**

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Cr</b>	<b>Mo</b>	<b>S</b>	<b>P</b>
Typical	0.07	0.6	0.3	1.3	0.5	0.02	0.01
Specification	0.09 max	0.40-0.75	0.20-0.40	1.0-1.50	0.40-0.65	0.03 max	0.03 max

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>YS at 0.2% offset, MPa</b>	<b>EL%</b>
Typical	PWHT: 690°C for 1 hr.	625	540	24
Specification		550 min	460 min	16 min

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Approx. Pcs/Carton</b>	<b>Carton/Box</b>	<b>Approx. wt. of 1000 pcs, Kg.</b>
2.5 x 350	60-90	246	4	20
3.15 x 450	100-130	116	4	43
4.0 x 450	140-180	76	4	65
5.0 x 450	190-240	50	4	98