

CROMOTEN V

AWS A/SFA 5.5 **E8013-G**

LOW ALLOY STEEL (High Temperature)

CLASSIFICATION:

EN ISO 3580-A
E Z R 12

KEY FEATURES:

- Rutile coated electrode
- Typical 1.2Cr-0.5Mo-V type low alloy steel deposit
- Especially suited for pipe welding due to its easy striking characteristics
- Excellent resistance to creep upto 550°C
- 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 550°C
- Application in oil refineries, thermal and chemical plants
- For welding IS steel 07Cr90Mo55
- For boiler heads and spares of similar composition
- Suitable for ASTM SA-213 Gr.T2/T11/ T12,SA-335 Gr.P2/P11/P12 and similar steels

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


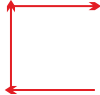
C	Mn	Si	Cr	Mo	V
0.1	0.6	0.3	1.3	0.5	0.25

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	PWHT: 690°C for 1 hr.	610	530	26
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 REDRYING CONDITION: 120°C for ½ hr.
3.15 x 350	100-140	
4.0 x 450	140-180	
5.0 x 450	190-250	
		All Positions, except vertical Downwards 

Available in Standard carton packing of 16 kg box containing 4 cartons 4 kg each. Also available in vacuum packing