ador
peace of mind™

CROMOTEN V

LOW ALLOY STEEL (High Temperature)

Rutile type Electrode best suited for creep resistance application upto 550°C.

CLASSIFICATION : EN ISO 3580-A	AWS A/SFA 5.5
E Z R 12	E 8013-G

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

WELDING POSITION : 

AC (70 OCV)/DCEN

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

REDRYING CONDITION : 120°C for ½ hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr
Typical	0.07	0.6	0.3	1.3
Specification	0.05-0.09	0.40-0.65	0.15 - 0.35	1.0-1.50
	Mo	**V**	**S**	**P**
Typical	0.5	0.25	0.02	0.01
Specification	0.40-0.65	0.20-0.40	0.03 max	0.03 max

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

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	227	4	22
3.15 x 450	100-130	117	4	42
4.0 x 450	140-180	76	4	65
5.0 x 450	190-240	45	4	111