



# Cromoten C PHT Batch

LOW ALLOY STEEL (High Temperature)

Basic type Electrode for welding 2.25 Cr - 1 Mo cast steels.

CLASSIFICATION : EN 1599      AWS A/SFA 5.5  
E CrMo2 B 32 H5      E 9018-B3

**KEY FEATURES :**

- Basic type medium heavy coating
- Typical 2.25Cr-1Mo type weld
- Resistant to creep and heat upto 600°C
- Deposition efficiency of 105%
- Necessary preheat and interpass temperature need to be maintained
- All position capability

WELDING POSITION :

AC (70 OCV)/DCEP

**TYPICAL APPLICATIONS :**

- Welding of alloy cast steel grade GS-17CrMo55, GS-18CrMo9-10
- Low alloy steel steam boilers, super heaters, hydro-crackers and piping operating at service temperatures upto 600°C
- Repair of high tensile steel castings
- Welding of higher strength piping and forgings
- Equipment for oil refining industries

REDRYING CONDITION : 300°C for 1 hr. (Also available in vacuum packed condition)

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

	C	Mn	Si	Cr	Mo	S	P
Typical	0.08	0.8	0.4	2.2	1.0	0.02	0.02
Specification	0.05-0.12	0.60-0.90	0.25-0.45	2.0-2.50	0.90-1.20	0.025 max	0.025 max

**MECHANICAL PROPERTIES OF ALL WELD METAL :**

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at 0°C, J
Typical	PWHT: 710°C	655	570	20	56
Specification	for 4 hr.	620 min	530 min	17-25	40 min

Diffusible H2 Content: <5 ml/100 gm

**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	225	4	22
3.15 x 450	100-140	118	4	42
4.0 x 450	140-180	78	4	64
5.0 x 450	190-250	53	4	94

EQUIVALENT : GMAW wire: Automig-90S-B3

GTAW filler: Tigfil-90S-B3