



# Cromoten PHT Spl

LOW ALLOY STEEL (High Temperature)

Basic coated Electrode for welding of 1.25 Cr-0.5 Mo creep resistant steel.

CLASSIFICATION : EN 1599      AWS A/SFA 5.5

E CrMo1 B 32 H5      E 8018-B2

### KEY FEATURES :

- Basic type medium heavy coating
- Low alloy Cr-Mo weld deposit
- Necessary preheat and interpass required followed by PWHT at 690°C
- Excellent resistance to cracking and creep upto 600°C
- Radiographic quality weld deposit
- Positional welding capability

WELDING POSITION :



AC (70 OCV)/DCEP

### TYPICAL APPLICATIONS :

- Welding of 1Cr-0.5Mo and similar creep resistant steels
- Repairing of high tensile castings
- For ASTM A 182 F2/F11/F12, A 387 2/11/12, A 355 P11/P12
- ASTM SA 387 Gr.11 plate, SA 335 P11 pipes
- In chemical and petrochemical industries to resist hydrogen attack, corrosion from sulphur bearing crude oil, stress corrosion cracking in sour environment
- Suitable for 13CrMo44, 15CrMo5 German steel

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	P+Sn
Typical	0.1	0.7	0.4	1.4	0.5	0.01	0.007	0.01
Specification	0.05-0.12	0.50-0.90	0.25-0.60	1.0-1.50	0.45-0.65	0.015 max	0.010 max	0.016 max

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -20°C, J
Typical	PWHT: 690°C	600	515	26	75
Specification	for 12 hrs	550 min	460 min	22-28	54 avg.

Hardness, 3 Layer: 200 BHN max

Diffusible H2 Content: <5 ml/100 gm

SPECIAL TESTS : Creep Rupture Test at 540°C

### 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	250	4	20
3.15 x 450	100-130	113	4	44
4.0 x 450	140-180	77	4	64
5.0 x 450	190-230	11	4	98