



# CROMOTEN 9L

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E8018-B8L**

### CLASSIFICATION:

EN ISO 3580-A  
E CrMo9L B 32 H5

### KEY FEATURES:

- Basic type heavy coating
- Extra low carbon 9Cr type low alloy weld deposit
- Resistant to corrosion and hydrogen attack at high temperatures
- Air hardenable alloy
- Optimum combination of strength, toughness with heat resistance
- Radiographic quality weld deposit

**APPROVALS:** CE

### TYPICAL APPLICATIONS:

- Suitable for welding of 9Cr type P5B materials in forging, pipes, tubes and casting form
- Welding of ferritic martensitic chrome steels
- For general corrosion and heat resistance application
- Application in Power plants, Oil refineries, Chemical and Petrochemical industries

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


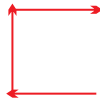
C	Mn	Si	Cr	Mo
0.045	0.8	0.5	8.5	1.1

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	PWHT: 740°C for 1 hr.	610	500	22
Specification		550 min	460 min	19 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 <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15x 350	100-140		
4.0 x 350	140-180		
5.0 x 450	190-250		

Available in Standard carton packing of 20 kg box containing 4 cartons each. Also available in vacuum packing

### EQUIVALENT:

GMAW	GTAW
Automig 80S-B8L	Tigfil 80S-B8L