



COROTHERME (SPL)

CODIFICATION : AWS : SFA 5.5 E8018-W2

CHARACTERISTICS AND APPLICATIONS :

Corotherme (SPL) is a special electrode depositing a 0.5Cr - 0.7Ni - 0.5Cu weld metal ideally suited for welding weathering steels to resist high temperature atmospheric corrosion. Ideal for welding steels like Corten steels used in chemical, petrochemical and railway industries to resist atmospheric corrosion.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	C	Mn	Si	Cr	Ni	Cu	S	P
Percent	0.065	0.65	0.40	0.55	0.75	0.50	0.018	0.018

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L = 4d)%	CVN Impact Strength at minus 20°C (Joules)
556	475	27	30

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	: 6.3x450	5x450	4x450	3.15x450	2.5x350
Dia x Length					
Current Range (Amps)	: 250-300	200-250	150-190	110-150	70-100
Qty.(Pcs./Carton)	: 25	35	55	75	125

APPROVAL: Indian Navy

PRECAUTIONS:

1. Ensure the electrodes are dry. In case of moisture pick-up, rebake as per our standard practice.