



## CROMOTHERME-2

**CODIFICATION :** AWS : SFA 5.5 E9018-B3  
IS : 1395 E63 B B3 2 6 Fe

### CHARACTERISTICS AND APPLICATIONS :

An iron powder, low hydrogen electrode producing a weld deposit containing 2.25Cr - 1Mo which is oxidation resistant up to 575°C. Suitable for welding 2.25Cr - 1Mo, Cr-Mo-V steels as well as cast steels of similar composition.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	: C	Mn	Si	Cr	Mo	S	P
Percent	: 0.06	0.80	0.44	2.40	1.10	0.025	0.025

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL : (PWHT: 690°C FOR 1 HR)

UTS (MPa)	YS (MPa)	Elongation (L = 4d)%	Creep Strength (1% offset in 10,000 hrs) at 550°C-12 kgf/mm <sup>2</sup> at 575°C-8.5 kgf/mm <sup>2</sup>
644	554	22.0	

### CURRENT AND PACKING DATA: DC(+)

Size (mm)	: 6.3x450	5x450	4x350	3.15x350	2.5x350
Dia x Length					
Current Range (Amps)	: 260-320	180-240	140-180	100-130	70-100
Qty.(Pcs./Carton)	: 25	35	55	75	125

**APPROVALS:** Adani Infra, BHEL, CIB-MP, EIL, NTPC, PDIL, Reliance (SASAN Power)

### PRECAUTIONS:

1. Redry the electrodes as per our standard recommended practice.
2. Use short arc during welding.