



CROMOTHERME-23

CODIFICATION : AWS : SFA 5.5 E9015-B23 (Old E9018-G)

CHARACTERISTICS AND APPLICATIONS :

◆ A stable and steady arc, which is easy to strike and re-strike. ◆ Easy slag removal and finely rippled smooth beads. ◆ Weld metal of having less impurities i.e. S, P will improve the impact property at subzero temperatures. ◆ Ideally suited for welding creep-resisting steels of similar composition. ◆ Specially applicable wherever prolonged heat treatment cycles are involved. ◆ Ideal for welding P23 material welding.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	P	S	Cr	Ni	Mo	V	Nb	N	Al	W	Cu	B
Percent :	0.06	0.7	0.30	0.010	0.007	2.2	0.3	0.2	0.2	0.03	0.03	0.02	1.8	0.10	0.004

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT : 740^oC FOR 2 HRS)

UTS (MPa)	YS (MPa)	Elongation (L = 4d)%
640	550	22

CURRENT AND PACKING DATA: DC(+)

Size (mm)	:	5 x 450	4 x 350	3.15 x 350	2.5 x 350
Dia x Length					
Current Range (Amps)	:	180-240	140-180	100-130	70-100
Qty.(Pcs./Carton)	:	30	50	75	100

APPROVALS: Adani Infra, Reliance (SASAN Power)

PRECAUTIONS:

1. Use short arc and stringer bead.
2. Ensure the electrodes are perfectly dry.
3. Re-dry the electrodes at 300^oC for one hour, as per standard recommended practice.