



CROMOTHERME-5

CODIFICATION: AWS : SFA 5.5 E8018-B6

CHARACTERISTICS AND APPLICATIONS:

Low hydrogen, iron powder electrode producing a weld deposit containing 5Cr - 0.5 Mo, which has excellent creep resistance at elevated temperatures up to 550°C. Typical applications include welding of 4-6% Cr steels in oil refinery, chemical plant and equipment.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	:	C	Mn	Si	Cr	Mo	S	P
Percent	:	0.06	0.90	0.40	5.20	0.50	0.020	0.020

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL : (PWHT : 740°C FOR 1 HR)

UTS (MPa)	YS (MPa)	Elongation (L = 4d)%	CVN Impact strength at RT(Joules)	Creep Strength at 550°C (1% offset in 10,000 hrs) 7 kgf/mm ²
614	505	22.0	60	

CURRENT AND PACKING DATA: DC(+)

Size(mm)	:	6.3x450	5x450	4x350	3.15x350	2.5x350
Dia x Length						
Current Range (Amps)	:	240-300	180-240	140-180	100-130	70-100
Qty.(Pcs./Carton)	:	25	35	55	75	125

APPROVAL: BHEL, EIL

PRECAUTIONS:

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

NOTE : Low carbon version Cromotherme - 5L conforming to AWS : E8018-B6L is also available.