

CROMOTHERME-5 (MOD)

CODIFICATION : AWS : SFA 5.5 E8018-B6

CHARACTERISTICS AND APPLICATIONS :

Cromotherme-5 (MOD) is a basic coated, low hydrogen type electrode depositing a weld metal with 5Cr-0.5Mo ideally suited for welding of creep resisting steels of similar composition where superior notch toughness required at sub-zero temperatures. The weld metal possesses excellent creep properties up to 550°C. Typical applications include welding of 5Cr-0.5Mo steels in oil refinery, chemical plant, and equipments. Specifically applicable wherever prolonged heat treatments are involved.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

| Element | C | Mn | Si | Cr | Mo | S | P + Sn |
|---------|------|------|------|------|------|-------|--------|
| Percent | 0.06 | 0.90 | 0.40 | 5.20 | 0.50 | 0.007 | 0.018 |

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

(PWHT: 740°C FOR 1 HR)

| UTS (MPa) | YS (MPa) | Elongation (L = 4d)% | CVN Impact strength at minus30°C(Joules) | Creep Strength at 550°C (1% offset in 10,000 hrs) |
|--------------|-------------|-------------------------|------------------------------------------------|---------------------------------------------------------|
| 614 | 505 | 24.0 | 35 | 7kgf/mm ² |

CURRENT AND PACKING DATA: DC(+)

| | | | | | |
|-------------------------|---|---------|---------|----------|---------|
| Size (mm) | : | 5x450 | 4x350 | 3.15x350 | 2.5x350 |
| Dia x Length | | | | | |
| Current Range (Amps) | : | 180-240 | 140-180 | 100-130 | 70-100 |
| Qty.(Pcs./Carton) | : | 30 | 50 | 75 | 100 |

PRECAUTIONS:

- 1 Redry the moist electrodes at 250-300°C for one hour as per standard recommended practice.
2. Use short arc and stringer bead.

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