Estd. 1966
DH sécheron
Complete Welding Support

CROMOTHERME-9

CODIFICATION : AWS : SFA 5.5 E8018-B8

CHARACTERISTICS AND APPLICATIONS :

A low hydrogen electrode yielding 9Cr - 1Mo deposit having excellent creep strength up to 600°C and resistance to oxidising atmospheres up to 700°C. Ideal for combating mineral oil attack at elevated temperatures. Applications include welding of 7 to 10Cr - 1Mo steels.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	Cr	Mo	S	P
Percent :	0.06	0.60	0.40	9.0	0.90	0.020	0.020

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

UTS (MPa)	YS (MPa)	Elongation (L= 4d)%	Creep Strength at 600°C (1% offset in 10,000 hrs)
574	485	21.0	6.5 kgf/mm²

CURRENT AND PACKING DATA : DC(+)

Size (mm) Dia x Length :	6.3x450	5x450	4x350	3.15x350	2.5x350
Current Range (Amps) :	280-350	180-240	140-180	100-130	70-100
Qty.(Pcs./Carton) :	25	35	55	75	125

APPROVAL: BHEL, CIB-MP, PDIL

PRECAUTIONS :

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