

## CROMOTHERME-9L

**CODIFICATION :**                      AWS    :    SFA 5.5 E8018-B8L

### CHARACTERISTICS AND APPLICATIONS :

A low hydrogen type electrode specially designed for welding of ferritic-martensitic chrome steels. The weld deposit contains low carbon 9Cr - 1Mo air hardenable weld metal calls for suitable preheat and post weld heat treatment. Weld deposits are of radiographic quality. Typical applications include welding of A387 Gr.9 plate, A335 P9 pipe, A217 C12 castings, A213 T9 tubes, etc.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	P	S	Ni	Cr	Mo
Percent :	0.04	0.60	0.45	0.021	0.020	0.10	9.50	1.00

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

**(PWHT: 740°C FOR 1 HR)**

UTS (MPa)	YS (MPa)	Elongation (L=4d) %
574	485	24.0

### CURRENT & 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

### PRECAUTIONS:

1. Use a short arc.
2. Ensure that the electrodes are perfectly dry. It is a safe and good practice to rebake electrodes at 300°C for an hour, cool in the oven to 100°C and transfer them to another oven maintain at 70°C for direct use.