



## CROMOTHERME-1(MOD)

**CODIFICATION :**

AWS	:	SFA 5.5 E8018-B2
IS	:	1395 E 55BB2 26Fe

**CHARACTERISTICS AND APPLICATIONS :**

Weld metal having lesser impurities i.e. S, P, will improve the subzero impact property and retains its mechanical properties after prolonged heat treatments. Ideal for welding similar composition materials. The weld metal displays excellent tensile strength and creep resistance. Specially applicable wherever the impact property requirement at subzero temperatures up to minus 20°C.

**TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :**

Element	: C	Mn	Si	Cr	Mo	S	P	Sn	As	Sb
Percent	: 0.06	0.76	0.49	1.25	0.50	0.007	0.010	0.002	0.004	0.002

**TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:**

**(PWHT: 690°C FOR 1 HR)**

UTS (MPa)	YS (MPa)	Elongation (L= 4d)%	CVN Impact Strength at minus 20°C (Joules)	Creep Strength at 550°C (1% offset in 10000 hrs.) 12 kgf/mm <sup>2</sup>
620	530	22	80	

**DIFFUSIBLE HYDROGEN CONTENT:** 5 ml/100 gms of weld metal (max.).

**CURRENT AND PACKING DATA: DC(+)**

Size (mm)	:	6.3x450	5x450	4x350	3.15x350	2.5x350
Dia x Length						
Current Range	:	250-300	200-250	140-180	100-130	70-100
(Amps)						
Qty.(Pcs./Carton)	:	25	30	50	75	100

**APPROVALS: BHEL**

**PRECAUTIONS:**

1. Rebake the electrodes at 250-300°C as per our standard recommended practice.
2. Use short arc and stringer bead.

**Note:** Low carbon version Cromotherme 1L(MOD) conforming to AWS:E7018-B2L is also available.