CROMOTHERME-2L

CODIFICATION: AWS: SFA 5.5 E8018-B3L

CHARACTERISTICS AND APPLICATIONS:
A low hydrogen type electrode depositing 2Cr - 1Mo low carbon weld metal. The weld metal possesses controlled hardness, excellent mechanical properties, creep properties. Suitable for service temperature up to 600°C.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:
Element: C Mn Si Cr Mo S P
Percent: 0.045 0.78 0.50 2.20 1.0 0.020 0.020

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:
(PWHT: 690°C FOR 1 HR)
UTS (MPa) YS (MPa) Elongation (L = 4d)%
634 535 18

CURRENT AND PACKING DATA: DC(+)
Size (mm): 6.3x450 5x450 4x350 3.15x350 2.5x350
Dia x Length
Current Range (Amps): 260-320 180-240 140-180 100-130 70-100
Qty.(Pcs./Carton): 25 35 55 75 125

APPROVALS: BV

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