

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	YS	Elongation
(MPa)	(MPa)	(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	:	260-320	180-240	140-180	100-130	70-100
(Amps)						
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.