



CROMOTHERME-2(MOD)

CODIFICATION : AWS : SFA 5.5 E9018-B3
IS : 1395 E63 B B3 2 6 Fe

CHARACTERISTICS AND APPLICATIONS :

A low hydrogen iron powder electrode depositing 2.25Cr - 1Mo weld metal having low level of impurities and exhibiting excellent toughness up to -18°C. Weld metal retains its mechanical properties even after prolonged heat treatments. Ideal for welding steels of similar composition to achieve tough weld metals.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element:	C	Mn	Si	Cr	Mo	S	P	P+Sn
Percent :	0.055	0.69	0.30	2.25	1.1	0.007	0.010	0.016

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 18°C (Joules)
646	554	22.0	100

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	30	50	75	100

PRECAUTIONS:

1. Rebake the electrodes at 250-300°C for one hour as per our standard recommended practice.
2. Use short arc during welding.

NOTE: Low carbon version cromotherme -2L (MOD) conforming to AWS : E8018 - B3L is also available.