CROMOTHERME-9

CODIFICATION: AWS: SFA 5.5 E8018-B8

CHARACTERISTICS AND APPLICATIONS:
A low hydrogen electrode yielding 9Cr-1Mo deposit having excellent creep strength up to 600°C and resistance to oxidising atmospheres up to 700°C. Ideal for combating mineral oil attack at elevated temperatures. Applications include welding of 7 to 10Cr-1Mo steels.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:
Element: C Mn Si Cr Mo S P
Percent: 0.06 0.60 0.40 9.0 0.90 0.020 0.020

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:
(PWHT: 740°C FOR 1 HR)
UTS (MPa) YS (MPa) Elongation (L = 4d)% Creep Strength at 600°C (1% offset in 10,000 hrs)
574 485 21.0 6.5 kgf/mm²

CURRENT AND PACKING DATA: DC(+)
Size (mm): 6.3x450 5x450 4x350 3.15x350 2.5x350
Dia x Length
Current Range (Amps): 280-350 180-240 140-180 100-130 70-100
Qty. (Pcs./Carton): 25 35 55 75 125

APPROVAL: BHEL, CIB-MP, PDIL

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