

## CROMOTHERME

**CODIFICATION :**                      AWS    :    SFA 5.5 E8018-B1

### CHARACTERISTICS AND APPLICATIONS :

Cromotherme is a basic coated hydrogen controlled electrode. Ideally suited for welding of creep resistant steels of similar composition used in power plants, boilers, oil refineries and chemical plants.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	Cr	Mo	S	P
Percent :	0.07	0.60	0.30	0.50	0.50	0.020	0.020

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

(PWHT : 690°C FOR 1 HR)

UTS	YS	Elongation
(MPa)	(MPa)	(L= 4d)%
564	446	20.0

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

Size (mm)	:	6.3x450	5x450	4x350	3.15x350	2.5x350
Dia x Length						
Current Range	:	250-300	180-240	140-180	100-130	70-100
(Amps)						
Qty.(Pcs./Carton)	:	25	35	55	75	125

### PRECAUTIONS :

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