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 (MPa)      YS (MPa)  Elongation (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.