



CROMOTEN 1

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E8018-B1**

CLASSIFICATION:

EN ISO 3580-A
E CrMo0.5 B 32 H5

IS 1395
E55 B-B1

KEY FEATURES:

- Basic coated iron powder electrode
- Typical 0.5Cr-0.5Mo weld deposit
- Smooth and stable arc
- Resistance to stress cracking
- Maximum service temperature 550°C

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of 0.5Cr-0.5Mo and similar creep resistant steels
- For high temperature and high pressure boilers, chemical and oil refining industries
- Cr and Cr-Mo bearing steels at elevated temperature service for steam production plants, steam pipes
- Electric power plant, Super heaters

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Mo
0.06	0.7	0.5	0.5	0.5


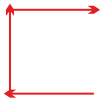
MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Specifications	PWHT: 620°C for 1 hr.	550 min	460 min	19 min

Hardness (3 Layer): 220 BHN Max

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.5 x 350	60-90	 AC (70 OCV)/DCEP All Positions, except vertical Down  REDRYING CONDITION: 250-300°C for minimum 1 hr.
3.15 x 450	100-140	
4.0 x 450	140-180	
5.0 x 450	190-250	

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kg each. Also available in vacuum packing