

CROMOTEN 9L

AWS A/SFA 5.5 E8018-B8L

LOW ALLOY STEEL (High Temperature)

CLASSIFICATION:

EN ISO 3580-A
E CrMo9L B 32 H5

KEY FEATURES:

- Basic type heavy coating
- Extra low carbon 9 Cr type low alloy weld deposit
- Resistant to corrosion and hydrogen attack at high temperatures
- Air hardenable alloy
- Optimum combination of strength, toughness with heat resistance
- Radiographic quality weld deposit

APPROVALS: CE

TYPICAL APPLICATIONS:

- Suitable for welding of 9% Cr type P5B materials in forging, pipes, tubes and casting form
- Welding of ferritic martensitic chrome steels
- For general corrosion and heat resistance application
- Application in Power plants, Oil refineries, Chemical and Petrochemical industries

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:



C	Mn	Si	Cr	Mo
0.045	0.8	0.5	8.5	1.1

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	PWHT: 740°C for 1 hr.	610	500	22
Specification		550 min	460 min	19 min

Diffusible H₂ Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm 3.15 x 350 4.0 x 450 5.0 x 450	Amperage, A 100-140 140-180 190-250	 AC (70 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
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Available in Standard carton packing of 20 kg box containing 4 cartons each. Also available in vacuum packing

EQUIVALENT:

GMAW	GTAW
Automig 80S-B8L	Tigfil-80S-B8L