



CROMOTEN C

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 **E9018-B3**

CLASSIFICATION:

EN ISO 3580-A
E CrMo2 B 32 H5

KEY FEATURES:

- Basic coated
- Low alloy steel Cr-Mo deposit
- Resistant to creep and heat upto 600°C
- Ductile and crack resistant and heat treatable weld
- Radiography quality weld metal

APPROVALS: ABS/IBR/NPCIL/NTPC/CE

TYPICAL APPLICATIONS:

- Welding of 2.25Cr-0.5Mo and 2.25Cr-1Mo type creep resistant steels
- Cr-Mo and Cr-Mo-V bearing steels for high temperature applications
- Main steam pipes of boilers in electric power plant, Boiler super heaters
- Joining of P5A materials
- Suitable for 12CrMo9-10, 10CrSiMoV7 German steels
- Joining ASTM A 335 Gr.P22, A 387 Gr.22 materials
- Application in refineries, power plants, pressure vessels, boilers

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

| C | Mn | Si | Cr | Mo |
|------|-----|-----|-----|------|
| 0.08 | 0.6 | 0.4 | 2.3 | 0.95 |


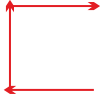
MECHANICAL PROPERTIES OF ALL WELD METAL:

| | Condition | UTS, MPa | YS at 0.2% offset, MPa | EL% |
|---------------|-----------------------|----------|------------------------|--------|
| Typical | PWHT: 690°C for 1 hr. | 660 | 580 | 22 |
| Specification | | 620 min | 530 min | 17 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 REDRYING CONDITION: 250-300°C for minimum 1 hr. | All Positions, except vertical Down  |
| 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 each. Also available in vacuum packing

EQUIVALENT:

| GMAW | GTAW | FCAW | SAW | |
|----------------|---------------|--------------------|-------------------|--------------|
| | | | Flux | Wire |
| Automig 90S-B3 | Tigfil 90S-B3 | Automig FC 91T1-B3 | Automelt B20 Plus | Automelt EB3 |