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DNH sécheron
Complete Welding Support

# CROMOTHERME-2(16)

**CODIFICATION:** AWS : SFA 5.5 E9016-B3

## CHARACTERISTICS AND APPLICATIONS:

Low hydrogen electrode depositing 2.25Cr – 1Mo weld metal, display remarkable strength and creep resistance at elevated temperatures up to 575°C. It is used for welding 2¼ Cr-1 Mo creep resistant steel and Cr-Mo-V steels resistant to hydrogen under pressure as well as for cast steels of a similar composition to the weld metal. Typical applications include steam boiler construction, welding of steam and super-heater piping, power plants, oil refinery and chemical plants.

## TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

| Element | C | Mn | Si | P | S | Cr | Mo |
|---|---|---|---|---|---|---|---|
| Percent | 0.060 | 0.80 | 0.50 | 0.023 | 0.022 | 2.25 | 1.00 |

## TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL: (PWHT: 690°C FOR 1 HR)

| UTS (MPa) | YS (MPa) | Elongation (L= 4d)% |
|---|---|---|
| 650 | 550 | 23.0 |

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

| Size (mm) Dia x Length | 5x450 | 4.0x450 | 3.15x450 | 2.5x350 |
|---|---|---|---|---|
| Current Range (Amps) | 200-250 | 150-190 | 100-140 | 70x100 |
| Quantity (Pcs./Carton) | 35 | 55 | 75 | 100 |

## PRECAUTIONS:

1. Re-dry the electrodes at 250-300°C for one hour, as per our standard recommended practice.
2. Use short arc and stringer bead.