



CROMOTHERME-24

CODIFICATION : AWS : SFA 5.5 E9015-B24

CHARACTERISTICS AND APPLICATIONS :

♦ A stable and steady arc which is easy to strike and re-strike. ♦ Easy slag removal and finely rippled smooth beads. ♦ Weld metal of having lesser impurities i.e. S, P will improve the subzero impact property. ♦ The electrode is used for welding similar composition materials and SA-182, F22V SA-336, F22V & SA-541, 22V. ♦ Specially applicable wherever prolonged heat treatments cycles are involved. ♦ Basically it is used for fabricating desulphurization reactors, heavy section pressure vessels having similar composition.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	P	S	Cr	Ni	Mo	V	Nb	N	Al	Ti	Cu	B
Percent :	0.06	0.7	0.30	0.012	0.007	2.2	0.3	1.0	0.2	0.03	0.04	0.02	0.05	0.1	0.004

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

(PWHT : 740°C FOR 2 HRS)

UTS	YS	Elongation
(MPa)	(MPa)	(L = 4d)%
640	550	22

CURRENT AND PACKING DATA : DC(+)

Size (mm)	:	5 x 450	4 x 350	3.15 x 350	2.5 x 350
Dia x Length					
Current Range	:	180-240	140-180	100-130	70-100
(Amps)					
Qty.(Pcs./Carton)	:	35	55	75	100

PRECAUTIONS :

1. Ensure the electrodes are dry. Re-dry the electrodes at 250-300°C for one hour.
2. Use short arc, low current and stringer beads.