



## CROMOTHERME-2L(MOD)

**CODIFICATION:** AWS : SFA 5.5 E8018-B3L

### CHARACTERISTICS AND APPLICATIONS:

Low carbon, low hydrogen, iron powder electrode depositing 2.25Cr - 1 Mo weld metal having low level of impurities and exhibiting excellent toughness up to minus 18°C. Weld metal retains its mechanical properties even after prolonged heat treatments. The weld metal displays excellent creep resistance with controlled hardness. Ideal for welding steels of similar composition to achieve tough weld metals.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	P	S	Cr	Mo	P+Sn
Percent	: 0.040	0.70	0.30	0.010	0.007	2.25	1.10	0.016

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 690°C FOR 1 HR)

UTS	YS	Elongation	CVN Impact at minus
(MPa)	(MPa)	(L = 4d)%	18°C (Joules)
630	530	24.0	100

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

Size (mm)	:	6.3x450	5x450	4x350	3.15x350	2.5x350
Dia x Length	:					
Current Range	:	260-320	180-240	140-180	100x130	70x100
(Amps)	:					
Quantity	:	25	35	55	75	100
(Pcs./Carton)	:					

### 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.