



CRO MOTHERME E-5(15) MOD

CODIFICATION: AWS : SFA 5.5 E8015-B6

CHARACTERISTICS AND APPLICATIONS:

It is low hydrogen electrode producing a weld deposit containing 5Cr – 0.5Mo, which has excellent creep resistance at elevated temperatures up to 550°C. The weld metal displays excellent creep resistance with controlled hardness. This electrode is used for welding creep resistant steel and cast steels of similar composition. 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	: 0.06	0.70	0.40	0.018	0.012	5.10	0.50

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 740°C FOR 1 HR)

UTS	YS	Elongation	CVN Impact at minus
(MPa)	(MPa)	(L = 4d)%	10°C (Joules)
605	500	22.0	60

CURRENT AND PACKING DATA: DC(+)

Size (mm)	: 5x450	4x350	3.15x350	2.5x350
Dia x Length				
Current Range	: 180-240	140-180	100-140	70-100
(Amps)				
Quantity	: 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.