CROMOTHERME-9

CODIFICATION :

AWS : SFA 5.5 E8018-B8
EN ISO : 3580-A E CrMo9 B 4 2

CHARACTERISTICS AND APPLICATIONS :

Cromotherme-9 is a low hydrogen electrode yielding 9Cr - 1Mo deposit having excellent creep strength up to 600°C and resistance to oxidizing atmospheres up to 700°C. Ideal for combating mineral oil attack at elevated temperatures. Applications include welding of 7 to 10Cr - 1Mo steels.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	P	S	Cr	Ni	Mo	V	Nb	Cu
Percent :	0.075	0.70	0.40	0.016	0.010	8.60	0.10	1.00	0.02	0.004	0.02

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

PWHT	UTS (MPa)	YS (MPa)	Elongation (L = 5d)%	CVN Impact Strength at 20°C
740°C for 1 Hr	620	518	25	-
760°C for 2 Hrs	610	510	26	110

CURRENT AND PACKING DATA : DC(+)

Size (mm) Dia x Length :	6.3x450	5x450	4x350	3.15x350	2.5x350
Current Range (Amps) :	280-350	180-240	140-180	100-130	70-100
Qty.(Pcs./Carton) :	25	35	55	75	125

APPROVALS: BHEL, CE, CIB-MP, PDIL

PRECAUTIONS :

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