

CROMOTHERME-2

CODIFICATION :

AWS : SFA 5.5 E9018-B3
IS : 1395 E63 B B3 2 6 Fe
EN ISO : 3580-A E CrMo2 B 4 2

CHARACTERISTICS AND APPLICATIONS :

Cromotherme-2 is an iron powder, low hydrogen electrode producing a weld deposit containing 2.25Cr - 1Mo which is oxidation resistant up to 575°C. Suitable for welding 2.25Cr - 1Mo, Cr-Mo-V steels as well as cast steels of similar composition.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL (%):

Element	C	Mn	Si	P	S	Cr	Mo
Percent	0.060	0.80	0.44	0.025	0.020	2.40	1.10

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

(PWHT: 690°C FOR 1 HR)

UTS (Mpa)	YS (MPa)	Elongation (L = 5d)%	CVN Impact Strength at 20°C (Joules)	Creep Strength (1% offset in 10,000 hrs)
644	554	22.0	70	at 550°C: 12 kgf/mm ² at 575°C: 8.5 kgf/mm ²

CURRENT AND PACKING DATA: DC(+)

Size (mm) Dia x Length	6.3x450	5x450	4x350	3.15x350	2.5x350
Current Range (Amps)	260-320	180-240	140-180	100-130	70-100
Qty. (Pcs./Carton)	25	35	55	75	125

APPROVALS: Adani Infra, BHEL, CE, CIB-MP, EIL, NTPC, PDIL, Reliance
(SASAN Power)

PRECAUTIONS:

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

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