Cromoten 9

LOW ALLOY STEEL (High Temperature)

Basic coated 9Cr type low alloy Welding Electrode.

CLASSIFICATION :	EN 1599	AWS A/SFA 5.5	APPROVALS :
	E CrMo9 B 32 H5	E 8018-B8	DNV

KEY FEATURES :

- Basic type heavy coating
- 9Cr type low alloy weld deposit
- Resistant to corrosion and hydrogen attack at high temperatures
- Air hardenable alloy
- Optimum combination of strength, toughness with heat resistance
- Radiographic quality weld deposit
- Positional welding capability

WELDING POSITION : 

 AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Suitable for welding of 9% Cr type P5B materials in forging, pipes, tubes and casting form
- Welding of ferritic martensitic chrome steels
- For general corrosion and heat resistance application
- Application in Power plants, Oil refineries, Chemical and Petrochemical industries

REDRYING CONDITION : 300°C for 1 hr. (Also available in vacuum packed condition)

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Mo	S	P
Typical	0.08	0.6	0.4	9.2	1.1	0.01	0.02
Specification	0.05-0.10	0.50-1.0	0.20-0.70	8.0-10.0	0.85-1.20	0.025 max	0.025 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	PWHT: 740°C for 1 hr	605	495	22
Specification		550-650	460-540	19-26

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
3.15 x 350	100-140	208	4	24
4.0 x 350	140-180	135	4	37
5.0 x 450	190-250	89	4	56

EQUIVALENT : GMAW wire: Automig 80S-B8 GTAW filler: Tigfil-80S-B8