



# Cromoten D

LOW ALLOY STEEL (High Temperature)

Low hydrogen basic type Electrode for welding 5Cr-0.5 Mo steels.

CLASSIFICATION :	EN 1599	AWS A/SFA 5.5	APPROVALS :
	E CrMo5 B 32 H5	E 8018-B6	DNV/IBR

**KEY FEATURES :**

- Basic type iron powder electrode
- Low carbon 5Cr-0.5Mo type weld
- Weld deposit highly resistant to creep and heat upto 650°C
- Air hardenable weld
- Preheat and interpass should be maintained during welding
- All position capability

WELDING POSITION :			AC (70 OCV)/DCEP
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**TYPICAL APPLICATIONS :**

- Welding of 5 Cr-0.5 Mo creep resistant steels and equivalent grades
- Application in refineries, chemical and power plants, pressure vessels, boilers
- Joining P5B materials e.g. SA 336/336M Gr.F5, SA 387/387MGr.5

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

**CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :**

	C	Mn	Si	Cr
Typical	0.07	0.8	0.5	5.2
Specification	0.05-0.10	0.5-0.9	0.25-0.65	4.0-6.0
	Mo	Ni	S	P
Typical	0.5	0.1	0.02	0.02
Specification	0.45-0.65	0.40 max	0.03 max	0.03 max

**MECHANICAL PROPERTIES OF ALL WELD METAL :**

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at 27°C, J
Typical	PWHT: 740°C for 1 hr.	610	490	22	104
Specification		550-650	460-520	20-25	80-140

Hardness, 3 Layer: 225 BHN max

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.
2.5 x 350	60-90	238	4	21
3.15 x 450	100-140	106	4	47
4.0 x 450	140-180	79	4	63
5.0 x 450	190-250	53	4	93

EQUIVALENT : GMAW wire: Automig 80S-B6

GTAW Filler : Tigfil-80S-B6