

CROMOTEN 9

CLASSIFICATIONS

AWS A/SFA 5.5 E8018-B8

IDENTIFICATION: Name Printed

CHARACTERISTICS

A heavy coated basic type electrode specially designed for welding of ferritic martensitic chrome steels. The weld deposit, which contain approx. 9% Cr is air hardenable and therefore calls for suitable preheat and postheat treatment. Weld deposits are of radiographic quality.

TYPICAL APPLICATIONS

For welding 9% Cr plates, pipes and tubes
For general corrosion and heat resistance applications.

Forging: ASTM A336 Grade F9
Pipes: ASTM A335 Grade P9
Tubes: ASTM A199 Grade T9
ASTM A213 Grade T9
Castings: ASTM A 217 C 12

WELD METAL CHEMISTRY, (%)

C - 0.05-0.10	Mo - 0.85-1.20	Cr. - 8.0-10.0
Mn - 0.50-1.00	S - 0.025 max.	
Si - 0.20-0.70	P - 0.025 max.	
Diffusible H ₂ content <5 ml / 100gm of weld metal		

MECHANICAL PROPERTIES-ALL-WELD (PWHT 740 C/1 hr)

Condition	UTS MPa	YS MPa	% Elong. (L=4xd)
	550-650	460-540	19-26

APPROVALS

DNV E 8018-B8

CURRENT CONDITIONS: AC (70V), DC (+)

5.0	4.0	3.2
190-250	140-180	100-140

WELDING POSITIONS

F, H, V -up, OH

REDRYING CONDITIONS

300°C for 1 hour (Optionally also available in vacuum-packed condition)

PACKING DATA

Dia., mm	5.0	4.0	3.2
Length, mm	350	350	350
Pcs per carton, Nos	89	135	208
Cartons / box	4	4	4
Pcs per box, Nos	356	540	832
Approx. Wt. of 1000 pcs,kg	56	37	24



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