

# CROMOTEN C

## CLASSIFICATIONS

**AWS A/SFA 5.5** E9018-B3

**IDENTIFICATION:** Name Printed

## CHARACTERISTICS

An electrode for welding of 2.25%Cr-1.0% Mo creep resistant steels. Weld metal is creep and heat resistant upto 600°C. It gives excellent arc stability, arc smoothness and very easy slag removal. Weld metal is of X-ray quality.

## TYPICAL APPLICATIONS

Welding of 2.25%Cr-0.50%Mo and 2.25%Cr-1.0%Mo steels used in Refineries, Power plants, Chemical plants, Pressure vessels, Boilers. Suitable for joining P5A materials e.g. F22 grade of SA-182/182M; T22 grade of SA-213/213M; P22 grade of SA-335/335M; 22 grade of SA-387/387M etc. German steels e.g. 12 CrMo 9 10, 10 CrSiMoV7.

### WELD METAL CHEMISTRY, (%)

C - 0.05-0.09	S - 0.030 max.	Cr - 2.0-2.50
Mn - 0.45-0.75	P - 0.030 max.	
Si - 0.20 – 0.65	Mo - 0.9-1.20	
Diffusible H <sub>2</sub> content < 5 ml / 100gm of weld metal		

### MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	% Elong.
	MPa	MPa	(L=4xd)
PWHT at 690°C for 1 hr	625-740	540-640	20-24

## APPROVALS

<b>IBR</b>	E9018-B3	<b>TOYO</b>	E9018-B3
<b>ABS</b>	E9018-B3	<b>BHEL</b>	E9018-B3
<b>NPCIL</b>	E9018-B3		

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

5.0	4.0	3.2	2.5
190-250	140-180	100-140	60- 90

## WELDING POSITIONS

F, H, V-up, OH

## REDRYING CONDITIONS

300°C for 1 hour (Optionally)

### PACKING DATA

Dia., mm	5.0	4.0	4.0	3.2	2.5
Length, mm	450	450	350	450	350
Pcs per carton, Nos	54	75	93	112	230
Cartons / box	4	4	4	4	4
Pcs per box, Nos	216	300	372	448	920
Approx. Wt. of 1000 pcs,kg	91	66	54	44	22

### SPECIAL TESTS

TEST TYPE	REMARKS
Creep	Specimen did not rupture at 600°C, 100 MPa stress for min. 1000 hrs.
Rupture test	



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