

CROMOTEN D

CLASSIFICATIONS

AWS A/SFA 5.5 E8018-B6

IDENTIFICATION: Name Printed

CHARACTERISTICS

A low-hydrogen, iron-powder electrode. For welding of 5%Cr-0.5% Mo creep resistant steels. Weld metal is creep and heat resistant upto 650°C. Weld metal is of air-hardenable type, so proper care is required while welding. It gives excellent arc stability, arc smoothness and very easy slag removal. Weld metal is of X-ray quality.

TYPICAL APPLICATIONS

Welding of 5%Cr-0.50% Mo steels used in Refineries, Power plants, Chemical plants, Pressure vessels, Boilers. Suitable for joining P5B materials e.g. F5 grade of SA-336/336M; 5 grade of SA-387/387M, etc.

WELD METAL CHEMISTRY, (%)

C - 0.05 - 0.10	S - 0.030 max.	Diffusible H ₂
Cr - 4.0 - 6.0	Mn - 0.50 - 0.90	Content <5 ml/ 100gm
P - 0.030 max.	Si - 0.25 - 0.65	of weld metal
Mo - 0.45 - 0.65	Ni - 0.40 max.	

APPROVALS

DNV E 8018-B6

Toyo E 8018-B6

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 also available in vacuum-packed condition)

PACKING DATA

Dia., mm	5.0	4.0	3.2	2.5
Length, mm	450	450	450	350
Pcs per carton, Nos	53	79	106	238
Cartons / box	4	4	4	4
Pcs per box, Nos	212	316	424	952
Approx. Wt. of 1000 pcs,kg	93	63	47	21

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	% Elong.	CVN Impacts, J	Hardness,
	MPa	MPa	(L= 4xd)	+27°C	BHN
PWHT at 740°C for 1 hr	550-650	460-520	20-25	80-140	225 max.



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ADOR WELDING LIMITED

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