CHROMET 1X

CHROMET 1X is designed for prolonged elevated temperature service up to 550°C it deposits a weld metal containing 1.25% Cr and 0.5% Mo. The electrodes has improved temper embrittlement resistance with prolonged exposure at 400-600°C. Relevant trace elements such as P, Sn, As, and Sb are controlled to ensure low Bruscato X and Watanabe J factors.

CLASSIFICATIONS

AWS	A5.5	E8018-B2
BS EN	2493	ECrMo 1 B
DIN	8575	ECrMo 1 B 2 6

CHEMICAL ANALYSIS (TYPICAL)

% Carbon	0.06	**% Molybdenum**	0.055
% Manganese	0.70	**% Copper**	<0.05
% Silicon	0.25	**% Tin**	0.002
% Sulphur	0.012	**% Arsenic**	0.003
% Phosphorous	0.009	**% Antinomy**	0.002
% Chromium	1.25		

TYPICAL MECHANICAL PROPERTIES (ALL WELD METAL IN THE AS WELDED CONDITION)

	PWHT 690°C/1h	PWHT 690°C/5h	PWHT 690°C/5h +Step Cooled
2% Proof Stress	570 MPa	515 MPa	490 MPa
Tensile Strength	660 MPa	610 MPa	595 MPa
Elongation 5d	21%	25%	25%
Charpy V-Notch at +20°C	160J	200J	200J
Charpy V-Notch at -30°C	100J	160J	140J
Hardness HV as welded 300-320HV	220 - 250	220	190

PACKING DATA

DC+

Diameter (mm)	Electrode Length (mm)	Amps	Item Number	Pack Mass (Kg)
3.2	380	80 - 140	078-260	3 x 5
4.0	450	100 - 180	078-262	3 x 5.6

For more information contact the Afrox Customer Service Centre,
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AFROX