- LOW ALLOY ELECTRODES

PRODUCT DATA SHEET

CHROMET IX

CHROMET IX is designed for prolonged elevated temperature service up to 550°C it deposits a weld metal containing I.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 I B	
DIN	8575	ECrMo B 2 6	

CHEMICAL ANALYSIS (TYPICAL)

% Carbon	0.06	
% Manganese	0.70	
% Silicon	0.25	
% Sulphur	0.012	
% Phosphorous	0.009	
% Chromium	1.25	

% Molybdenum 0.055 % Copper <0.05</th> % Tin 0.002 % Arsenic 0.003 % Antinomy 0.002

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

	РWHT 690°С/Ih	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	I 60J	200J	200J
Charpy V-Notch at -30°C	1 OOJ	I 60J	I 40J
Hardness HV as welded 300-320HV	220 - 250	220	190

PACKING DATA

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

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