

PRODUCT DATA SHEET

Metrode Chromet IX



Chromet IX is designed for prolonged elevated temperature service up to 550°C, depositing a weld metal containing 1,25% Cr and 0,5% Mo. The electrodes have 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
EN	3580-A	E Cr MoI B H5
EN	3580-B	E5515-ICM H5

Typical Chemical Analysis

% 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	% Antimony	0,002
% Chromium	1,25		

Typical Mechanical Properties (All weld metal in the as welded condition)

	PWHT 690°C/1 hr	PWHT 690°C/5 hr	PWHT 690°C/5 hr +Step Cooled
0,2% Proof Stress	570 MPa	515 MPa	490 MPa
Tensile Strength	660 MPa	610 MPa	595 MPa
% Elongation on 5d	21	25	25
Charpy V-Notch at +20°C	160 J	200 J	200 J
Charpy V-Notch at -30°C	100 J	160 J	140 J
Hardness HV As Welded 300 - 320 HV	220 - 250	220	190

Packing Data (DC+)

Diameter (mm)	Current (A)	Electrode Length (mm)	Pack Mass (kg)	Item Number
3,2	80 - 140	380	3 x 5,0	W078260
4,0	100 - 180	450	3 x 5,6	W078262

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