

ROYAL CHROM – 2 (E 9018 B3)

AWS:SFA 5.5, E 9018 B3 IS : 814E 53 B-B3-26 Fe EN ISO 3580 A E CrMo 2 B 32 H5

Applications

Suitable for welding 2.25% Cr, 1% Mo steels. Low alloy steel boilers and pipeline operation, Repair of high tensile steel castings. Pipelines for oil refinery, power plant at service temperature up to 600 oC.

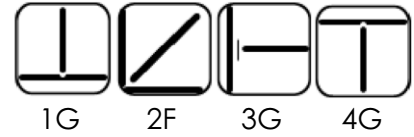
Characteristics on Usage

A medium heavy coated low hydrogen iron powder type electrode, welding in all positions. used for welding of similar Cr-Mo steel. Its deposition efficiency is 106% approximately, the weld metal is of radiographic quality and has creep resistance up to 600 oC. The weld metal gives 2.25% Cr and 1.0% Mo having excellent welding characteristics. Dry the electrode at 300 oC for obtaining best results.

Notes On Usage

- Preheat at 150 - 250 °C and postheat at 690 ± 15 °C.
- Dry the electrode at 250 - 300 °C for 60 Min- before use.

Welding Positions



Welding Positions

E.I.L., K.N.P.C ,IOCL,IBR, N.P.C.I.L.

LOW ALLOY HIGH TENSILE ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr%	Mo%
0.05- 0.12	0.90 Max	0.80 Max	0.030 Max	0.030 Max	2.0 – 2.50	0.90 – 1.20

Mechanical Properties Of Weld Metal

(After PWHT at 690 ± 15oC for 1 Hr soaking)

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	Hydrogen (Mercury method) in 100grm weld metal
620 Min	530 Min	17 % Min	5ml Max

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	AC/DC (+)	60-90
3.15 x 450	5	20		100-130
4.00 x 450	5	20		140-180
5.00 x 450	5	20		190-230