

ROYAL CHROM – 5 (E 8018 B6)

AWS : SFA 5.5, E 8018 B6 IS : E41 Bb626 Fe EN ISO 3580 A E CrMo 5 B 32 H5

Applications

It is used for welding of 5% Cr, 0.5% Mo steel for high temp application in oil refineries. Power plants, Petrochemical plants. Fertilizer Industries.

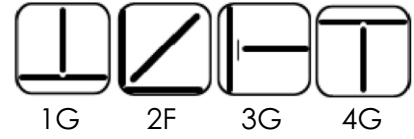
Characteristics on Usage

A low hydrogen iron powder type basic coated all position electrode. It gives weld deposit which has contain 5% Cr, 0.5% Mo for the welding of similar Cr-Mo steel. The weld metal is of radiographic quality and has creep resistance upto 650 oC. Dry the electrode at 300 oC for obtaining best results.

Notes On Usage

- Preheat at 150 - 250 °C and postheat at 690 ± 14 °C.
- Dry the electrode at 250 - 300 °C for 60 Min- before use.

Welding Positions



Approvals

K.N.P.C., IOCL

LOW ALLOY HIGH TENSILE ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr%	Mo%
0.05 – 0.09	0.50 – 0.90	0.25 – 0.50	0.030 Max	0.030 Max	4.0 – 6.0	0.45 – 0.65

Mechanical Properties Of Weld Metal

(After PWHT at 740 ± 15 oC for 1 Hr soaking)

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %
550 Min	460 Min	19 % Min

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	DC (+)	60-90
3.15 x 450	5	20		100-140
4.00 x 450	5	20		140-180
5.00 x 450	5	20		190-240