

# ROYAL CHROME – 9 (E 8018 B8)

AWS : SFA 5.5, E 8018 B8 EN ISO 3580 A E CrMo 9 B 32 H5

## Applications

It is used for welding of 9% Cr, plates, pipes, tubes. It is also used for welding of 7 to 10% Cr, 1% Mo steels, for general corrosion and heat resistance application, Surfacing of turbine Blades, Valve, Seats, Pump parts etc.,

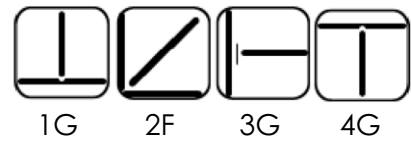
## Characteristics on Usage

A heavy coated low hydrogen electrode specially developed for welding of Ferritic, Martensitic chrome steels. It gives weld deposit which contains 9% Cr, 1% Mo having excellent creep strength up to 625 °C and resistance to oxidising atmosphere up to 700 °C. Proper preheating and post heating is required for welds made with these electrodes. The weld deposit gives radiographic quality of welds. Dry the electrode at 300 °C before welding to obtain best results.

## Notes On Usage

- Preheat at 150 - 250 °C and postheat at 740 ± 15 °C.
- Dry the electrode at 250 - 300 °C for 60 Min- before use.

## Welding Positions



## Approvals

K.N.P.C.

## Packing

Vaccum Pack

LOW ALLOY HIGH TENSILE ELECTRODES

## Chemical Composition Of Weld Metal

| C%          | Mn%     | Si%      | S%        | P%        | Cr %     | Ni %     | Mo %        |
|-------------|---------|----------|-----------|-----------|----------|----------|-------------|
| 0.05 - 0.10 | 1.0 Max | 0.90 Max | 0.030 Max | 0.030 Max | 8.0-10.5 | 0.40 Max | 0.85 – 1.20 |

## Mechanical Properties Of Weld Metal

| U.T.S.<br>(N/mm <sup>2</sup> ) | Y.S.<br>(N/mm <sup>2</sup> ) | ELONGATION<br>( L = 4d ) % |
|--------------------------------|------------------------------|----------------------------|
| 550 Min                        | 460 Min                      | 19 % Min                   |

## Packing and Welding Current

| SIZE ( mm )    | KG PER<br>PACKET | KG PER<br>CARTON | LBS PER<br>PACKET | LBS PER<br>CARTON | In Amps   | Current (Amps) |
|----------------|------------------|------------------|-------------------|-------------------|-----------|----------------|
| 2.50 x 350     | 2                | 10               | 11                | 44                | 60-90     | DC (+)         |
| 3.15 x 350/450 | 2                | 10               | 11                | 44                | 100 – 140 |                |
| 4.00 x 350/450 | 2                | 10               | 11                | 44                | 140 – 180 |                |
| 5.00 x 350/450 | 2                | 10               | 11                | 44                | 180 – 230 |                |