CHROMET 2X

CHROMET 2X is designed for prolonged elevated temperature service up to 600°C it deposits a weld metal containing 2.25% Cr and 1.0% 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	E9018-B3
BS EN	2493	ECrMo 2 B
DIN	8575	ECrMo 2 B 2 6

CHEMICAL ANALYSIS (TYPICAL)

% Carbon	0.06	**% Molybdenum**	1.05
% Manganese	0.70	**% Copper**	<0.05
% Silicon	0.25	**% Tin**	0.002
% Sulphur	0.012	**% Arsenic**	0.003
% Phosphorous	0.010	**% Antinomy**	<0.002
% Chromium	2.25		

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

	PWHT 690°C/1h	PWHT 690°C/5h	PWHT 690°C/5h +Step Cooled
2% Proof Stress	620 MPa	560 MPa	550 MPa
Tensile Strength	700 MPa	660 MPa	650 MPa
Elongation 5d	19%	24%	20%
Charpy V-Notch at +20°C	140J	70J	170J
Charpy V-Notch at -30°C	80J	140J	110J
Hardness HV as welded 300-320HV	220 - 250	195	205

PACKING DATA

DC+

Diameter (mm)	Electrode Length (mm)	Amps	Item Number	Pack Mass (Kg)
3.2	380	80 - 140	078-294	3 x 5
4.0	450	100 - 180	078-296	3 x 6

For more information contact the Afrox Customer Service Centre,
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AFROX