

PRODUCT DATA SHEET

Metrode Chromet 2X



Chromet 2X is designed for prolonged elevated temperature service up to 600°C depositing a weld metal containing 2,25% Cr and 1,0% 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	E9018-B3
EN	3580-A	E Cr Mo2 B H5
EN	3580-B	E6215-2CIM H5

Typical Chemical Analysis

% Carbon	0,06	% Molybdenum	1,05
% Manganese	0,7	% Copper	<0,05
% Silicon	0,25	% Tin	0,002
% Sulphur	0,012	% Arsenic	0,003
% Phosphorous	0,01	% Antimony	<0,002
% Chromium	2,25		

Typical Mechanical Properties (All weld metal)

	PWHT 690°C/1 hr	PWHT 690°C/5 hr	PWHT 690°C/5 hr +Step Cooled
0,2% Proof Stress	620 MPa	560 MPa	550 MPa
Tensile Strength	700 MPa	660 MPa	650 MPa
% Elongation on 5d	19	24	20
Charpy V-Notch at +20°C	140 J	70 J	170 J
Charpy V-Notch at -30°C	80 J	140 J	110 J
Hardness HV As Welded 300 - 320 HV	220 - 250	195	205

Packing Data (DC+)

Diameter (mm)	Current (A)	Electrode Length (mm)	Pack Mass (kg)	Item Number
3,2	80 - 140	380	3 x 5,0	W078294
4,0	100 - 180	450	3 x 6,0	W078296

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