

**ROYAL CHROM – 5 (E 8018 B6)**

AWS : SFA 5.5, E 8018 B6

IS : E41 BB626 Fe

**Applications**

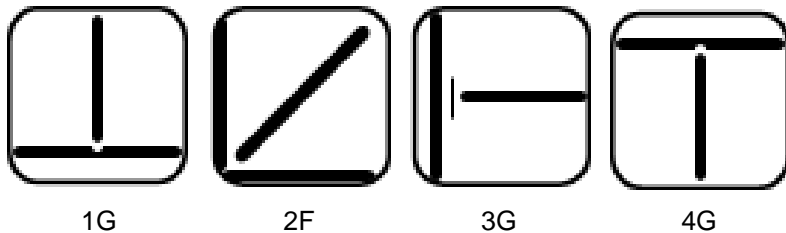
It is used for welding of 5% Cr, 0.5% Mo steel for high temp application in oil refineries. Power plants, Petrochemical plants. Fertilizer Industries.

**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 °C. Dry the electrode at 300 °C for obtaining best results.

**Notes On Usage**

- ✍ 1) Preheat at 150 - 250 °C and postheat at  $690 \pm 14$  °C.
- ✍ 2) Dry the electrode at 350-400 °C for 60 Min- before use.

**Welding Positions****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  $740 \pm 15^\circ\text{C}$  for 1 Hr soaking)

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

**Approvals**

K.N.P.C. ,IOCL

**Packing and Welding Current**

SIZE ( mm )	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	150	600	DC (+)	60-90
3.15 x 450	100	400		100-140
4.00 x 450	70	280		140-180
5.00 x 450	45	180		190-240