Chromet® 2 (SL 20G)

TOP FEATURES

- For welding creep and hydrogen resistant CrMo-steels
- Maximum service temperature 600°C
- DC-welding preferred
- 115 - 120% recovery

TYPICAL APPLICATIONS

- Steam generating power plant, eg piping, turbine castings, steam chests, valve bodies and boiler superheaters
- Chemical and petro-chemical industries

CLASSIFICATION

AWS A5.5	E9018-B3 H4R
EN ISO 3580-A	E CrMo2 B 3 2 H5
EN ISO 3580-B	E 6216-2C1M

CURRENT TYPE

DC+/AC

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV
+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb
Min.	0.05	0.50	not specified	not specified	not specified	2.00	not specified	0.90	not specified	not specified
Max.	0.10	0.90	0.80	0.025	0.030	2.50	0.3	1.20	0.2	0.01
Typical	0.07	0.8	0.60	0.01	0.02	2.3	0.1	1.0	0.1	0.01

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Properties after PWHT		Min.	Typical 690°C/1h
Tensile strength	(MPa)	630	670
0.2% Proof strength	(MPa)	530	570
Elongation (%)	4d	17	22
	5d	18	20
Reduction of area (%)		not specified	65
Impact ISO-V (J)	+20°C	47	140
Hardness (HV)		not specified	220-250

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	70-110
3.2 x 350	80-140
4.0 x 450	100-180

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	90	1.8	CHROMET2-25-2
3.2 x 350	VPMD	53	2.0	CHROMET2-32-2
4.0 x 450	VPMD	37	2.6	CHROMET2-40-2

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.