

Chromet® WB2

TOP FEATURES

- MMA all-positional electrode for C(F)B2 creep resisting steel.
- Basic coated MMA electrode made on matching core wire.
- Moisture resistant coatings giving very low weld metal hydrogen levels.
- Recovery is approx 120%

TYPICAL APPLICATIONS

- Turbine rotors, valves and casings

CLASSIFICATION

AWS A5.5 E9015-G H4

CURRENT TYPE

DC+/AC

WELDING POSITIONS

All position, except vertical down

CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Mo	Nb	V	N	B	Co
Min.	0.10	0.40	0.15	not specified	not specified	9.0	0.40	1.4	0.04	0.20	0.001	0.003	0.80
Max.	0.15	1.00	0.50	0.015	0.020	10.5	0.80	1.7	0.07	0.30	0.035	0.010	1.20
Typical	0.12	0.6	0.25	0.009	0.010	9.5	0.6	1.5	0.05	0.25	0.02	0.005	1.0

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

PWHT (760°C / 4h or equivalent)	Min.	Typical		High Temperature*		
		760°C/4h	760°C/10h	+600°C	+650°C	+700°C
Tensile strength (MPa)	650	735	730	425	325	256
0.2% Proof strength (MPa)	530	600	590	320	240	135
Elongation (%) 4d	17	23	21	21	34	30
5d	15	21	19	19	31	28
Reduction of area (%)	not specified	58	56	71	80	85
Impact ISO-V (J) +20°C	not specified	40	40	-	-	-
Hardness (HV)	not specified	230-260	230-260	-	-	-

*After PWHT at 730°C/12h + 730°C/12h.

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	350
4.0 x 450	450
5.0 x 450	450

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
4.0 x 450	CAN	80	5.5	CHWB2-40-1

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.