SPECIAL ALLOYS™

Chromet® 1 (SL 19G)

TOP FEATURES

- MMA electrode meeting AWS and ISO standards suitable for most power generation applications
- Basic flux, metal powder type coatings on low carbon high purity core wire
- Recovery is approximately 115%
- Moisture resistant coating gives very low metal hydrogen levels.

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	E8018-B2 H4
EN ISO 3580-A	E CrMo1 B 3 2 H5
EN ISO 3580-B	E 5518-1CM

CURRENT TYPE

DC+/AC

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV
+

CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

	C	Mn*	Si	S	P	Cr	Mo	Ni	Cu	Nb
Min.	0.05	0.50	not specified	not specified	not specified	1.00	0.45	not specified	not specified	not specified
Max.	0.12	0.90	0.80	0.025	0.030	1.40	0.65	0.3	0.2	0.01
Typical	0.07	0.8	0.5	0.01	0.02	1.25	0.55	0.1	<0.1	0.01

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Properties after PWHT:		Min.	Typical 690°C/1h
Tensile strength	(MPa)	550	640
0.2% Proof strength	(MPa)	460	570
Elongation (%)	4d	19	25
	5d	20	24
Reduction of area (%)		not specified	70
Impact ISO-V (J)	+20°C	47	160
Hardness (HV)		not specified	210

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	CAN	195	4.0	CHROMET1-25-1
3.2 x 350	CAN	112	4.1	CHROMET1-32-1
4.0 x 450	CAN	77	5.4	CHROMET1-40-1

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.