

Chromet[®] 1 (SI19G)

Key Features

- Basic all positional creep resistant electrode
- DC- polarity is preferred
- Supplied in Sahara Ready Pack (SRP)

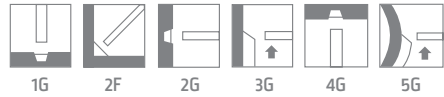
Typical Applications

- For welding creep resistant CrMo steels such as A387 Gr 11 & 12
- Maximum service temperature of 550°C

Conformances

AWS A5.5/A5.5M:	E8018-B2 H4
AS/NZS 4856-A:	E CrMo1 B 32 H5
AS/NZS 4856-B:	E 5218-1CM H5
DNV:	1Cr0,5Mo

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.5	350	CHROMET1SP25-1	SRP 1.3 kg (10 x SRP per carton)
3.2	350	CHROMET1SP32-1	SRP 1.7 kg (8 x SRP per carton)
4.0	350	CHROMET1SP40-1	SRP 1.5 kg (8 x SRP per carton)

Mechanical Properties - As required per AWS A5.5 & AS/NZS 4856-A

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ +20°C
Requirements - AWS	460 min	550 min	19 min	-
Requirements - AS/NZS	355 min	510 min	20 min	47 min
Typical Results (f) - Stress Relieved 1. 700C for 1 hour	570	640	24	180

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.06	0.75	0.6	0.015	0.010
	%Ni	%Cr	%Mo	%V	Diffusible Hydrogen
Typical Results - As Welded	<0.01	1.1	0.50	<0.08	<5 ml / 100 g

Typical Operation Procedures

Polarity	Current (amps)		
	2.5mm	3.2mm	4.0mm
DC±	60-90	80-130	120-180