

# Chromet® 2 (SL20G)

## Key Features

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

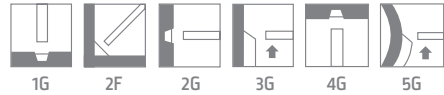
## Typical Applications

- For welding creep resistant CrMo steels such as A387 Gr 21 & 22
- Maximum service temperature 600°C

## Conformances

<b>AWS A5.5/A5.5M:</b>	E9018-B3 H4 R
<b>AS/NZS 4856-A:</b>	E CrMo2 B 3 2 H5
<b>AS/NZS 4856-B:</b>	E 6218-2C1M H5

## Welding Positions



## Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.5	350	CHROMET2-25-1	Can 4.0 kg (3 x Can per carton)
3.2	350	CHROMET2-32-1	Can 4.2 kg (3 x Can per carton)
4.0	450	CHROMET2-40-1	Can 5.4 kg (3 x Can 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
<b>Requirements - AWS</b>	530 min	620 min	17 min	-
<b>Requirements - AS/NZS</b>	400 min	500 min	18 min	47 min
<b>Typical Results (1) - Stress Relieved</b>	530	650	22	150
1. 695C for 1 hour				

## Deposit Composition

	%C	%Mn	%Si	%P	%S
<b>Typical Results - As Welded</b>	0.06	0.80	0.6	0.015	0.010
	%Ni	%Cr	%Mo	%V	Diffusible Hydrogen
<b>Typical Results - As Welded</b>	<0.01	2.3	1.0	<0.08	3 ml / 100 g

## Typical Operation Procedures

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