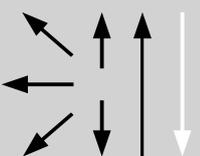


Classifications									
EN ISO 3580-A					AWS A5.5				
E CrMo1 B 4 2 H5					E8018-B2				
Characteristics and typical fields of application									
Basic covered CrMo alloyed electrode. Cryogenic, suitable for quenching and tempering; resistant to caustic cracking; creep resistant in short time range up to 500 °C (932 °F) and in long time range up to 570 °C (1058 °F). Electrode for heavy-duty steam boiler and superheater tube fabrication; for quenched and tempered steels.									
Base materials									
13CrMo4-5, G22CrMo5-4									
Typical analysis of all-weld metal (wt.-%)									
	C	Si	Mn	Cr	Mo	P	As	Sb	Sn
wt-%	0.06	0.25	0.85	1.20	0.50	< 0.012	< 0.010	< 0.005	< 0.005
Mechanical properties of all-weld metal									
Heat-treatment	Yield strength R _{p0.2}		Tensile strength R _m		Elongation A (L ₀ =5d ₀)		Impact work ISO-V KV J		
	MPa		MPa		%		+20 °C	-20 °C	-40 °C
sr (690 °C / 10 h)	460		550		22		120	100	60
sr + step cooling	460		550		22		120	100	50
Operating data									
	Polarity: DC (+)		Redrying: 300 – 350 °C / 2 h (572 – 662 °F)		ø mm	L mm	Amps A		
					2.5	350	80 – 105		
					3.2	350	100 – 150		
					4.0	350	140 – 200		
					3.2	450	100 – 150		
					4.0	450	140 – 200		
5.0	450	170 – 250							
Approvals									
TÜV (01752), CE									