

Classifications

EN ISO 3580-A	EN ISO 3580-B	AWS A5.5	AWS A5.5M
E CrMo2 B 4 2 H5	E 6215-2C1M	E9015-B3	E6215-B3

Characteristics and typical fields of application

Extra low content of trace elements; step-cooling tested; not sensitive to long term embrittlement. Manufacture of chemical apparatus, hydrocrackers; for welding work on heavy-duty boilers, superheaters, superheater lines; for welding of CrMo and CrMoV alloyed steels for the petrochemical industry.

Base materials

10 CrMo 9-10, 12 CrMo 9-10, 10 CrSiMoV 7, 15 CrMoV 5-10;
ASTM A335 Gr. P22, A217 Gr. WC9

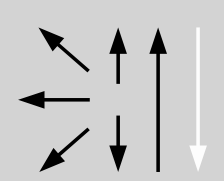
Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn	P	Cr	Mo	As	Sb	Sn	S
wt-%	0.07	0.25	0.70	≤ 0.012	2.20	0.90	≤ 0.010	≤ 0.005	≤ 0.005	≤ 0.010

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	-30 °C	-40 °C
aw	440	550	22	130	90	80
v	310	460	24	130		
sr + step-cooling	440	550	22	130	80	60

Operating data

	Polarity: DC (+)	Redrying: 300 – 350 °C / 2 h (572 – 662 °F)	ø (mm)	L mm	Amps A
			2.5	250	70 – 100
			3.2	350	100 – 145
			4.0	350	140 – 190
			3.2	450	100 – 145
			4.0	450	140 – 190
			5.0	450	160 – 240

Approvals

TÜV (01823), CE