

Phoenix SH Kupfer 1 K

Stick electrode, low-alloyed, basic

Classifications

EN ISO 3580-A	EN ISO 3580-B	AWS A5.5	AWS A5.5M
E CrMo1 B 4 2 H5	E 5518-1CM	E8018-B2	E5518-B2

Characteristics and typical fields of application

Basic covered CrMo alloyed electrode.

Tough, crack free, quenchable weld metal; resistant to coustic crack; creep resistant in short-term range up to 500 °C (932 °F), in long-term range to 570 °C (1058 °F). Electrode designated for pipe fabrication in heavy duty, steam boiler and super heated applications.

Base materials

13 CrMo 4-5, GS-22 CrMo 54

Typical analysis of all-weld metal (wt%)					
	С	Si	Mn	Cr	Мо
wt-%	0.06	0.30	0.90	1.0	0.50

Mechanical properties of all-weld metal

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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
sr	490	580	22	110
V	350	450	26	120

Operating data

	Polarity:	Redrying:	ø (mm)	L mm	Amps A
	DC (+)	250 – 350 °C / 2 h	2.5	350	80 - 100
← :		(572 – 662 °F)	3.2	350	110 – 145
			4.0	350	130 – 190
			5.0	450	160 – 230

Approvals

TÜV (01756), DB (10.132.15), CE