

## Classifications

EN ISO 3580-A	EN ISO 3580-B	AWS A5.5	AWS A5.5M
E ZCrMoV1 B 4 2 H5	E 6215-G	E9015-G	E6215-G

## Characteristics and typical fields of application

Basic covered CrMoV alloyed electrode.

Suitable for low alloyed, creep resistant cast steel similar or same chemical composition. Creep resistant for short term conditions up to 550 °C.

Phoenix SH Kupfer 3 KC is suited for steam-turbines, steam-pipes or valve cases.

It provides a good welding characteristics, flat smooth weld seams and an easy slag removal.

## Base materials

1.7706 – G17CrMoV5-10; 1.7357 – G17CrMo5-5

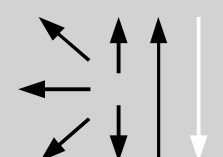
## Typical analysis of all-weld metal

	C	Si	Mn	Cr	Mo	V
wt.-%	0.13	0.40	1.0	1.4	1.05	0.25

## Mechanical properties of all-weld metal – typical values (min. values)

Heat-treatment	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
sr	520	630	18	40
v	450	610	18	40

## Operating data

	Polarity: DC +	Redrying: 250 – 350 °C / 2 h (572 – 662 °F)	ø mm	L mm	Amps A
			3,2	350	90 – 140
			4,0	350	140 – 190
			5,0	450	180 – 240

## Approvals

TÜV (03187), CE