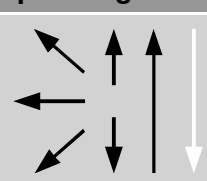


Classifications										
EN ISO 3580-A			EN ISO 3580-B		AWS A5.5		AWS A5.5M			
E Z CrMoWVNb9 0,5 2 B 4 2 H5			E 6215-G		E9015-G (E9015-B9 mod.)		E6215-G (E6215-B9 mod.)			
Characteristics and typical fields of application										
Basic covered CrMoNiWVNb alloyed electrode. Suitable for welding of high temperature martensitic steels in particular P 92 according to ASTM A 355. The electrode features good welding characteristics in out of position work, low spatter loss and an easy removable slag.										
Base materials										
1.4901 – X10CrWMoVNB9-2; NF 616 ASTM A355 Gr. P92 (T92); A213 Gr. T 92										
Typical analysis of all-weld metal (wt.-%)										
	C	Si	Mn	Cr	Mo	Ni	V	W	Nb	N
wt-%	0.11	0.2	0.6	8.8	0.5	0.7	0.2	1.6	0.05	0.05
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			
760 °C / ≥ 2 h	560		720		15		41			
Operating data										
	Polarity: DC (+)		Redrying: 300 – 350 °C / 2 h (572 – 662 °F / 2 h)		ø mm 2.5 3.2 4.0		L mm 300 350 350		Amps A 70 – 100 90 – 140 130 – 180	
Welding instruction										
Preheating	Interpass temperature			Cooling bevor PWHT			Postweld heat treatment			
200 – 250 °C (392 – 482 °F)	250 – 350 °C (482 – 662 °F)			≤ 100 °C (≤ 212 °F)			760 °C (1400 °F) / 2 h			
Approvals										
TÜV (09289), CE										