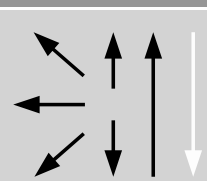


Classifications										
EN ISO 3580-A		EN ISO 3580-B		AWS A5.5		AWS A5.5M		Wst.-Nr.		
E Z CrMoWVNb9 1 1 B 4 2 H5		E 6215-G		E9015-G (E9015-B9 mod.)		E6215-G (E6215-B9 mod.)		1.4905		
Characteristics and typical fields of application										
Basic covered CrMoNiVWNb alloyed electrode. Good welding characteristics in out of position work; high temperature resistant matching weld metal. For the welding of high temperature resistant martensitic steels in particular X11CrMoWVNb9-1-1 (E911).										
Base materials										
1.4905 – X11CrMoWVNb9-1-1; ASTM A355 Gr. P911, A213 Gr. T911										
Typical analysis of all-weld metal (wt.-%)										
	C	Si	Mn	Cr	Mo	Ni	V	W	Nb	N
wt-%	0.11	0.25	0.6	8.8	1.0	0.7	0.2	1.0	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).		ø (mm) 3.2 5.0		L mm 350 450		Amps A 90 – 120 150 – 180	
Welding instruction										
Materials				Preheating		Postweld heat treatment				
200 – 250 °C / 200 – 300 °C				≤ 100 °C		760 °C / 2 h				
Approvals										
TÜV (07991), CE										