

Classifications

EN ISO 3580-A	EN ISO 3580-B	AWS A5.5	AWS A5.5M
E Z CrWV2 1,5 B 4 2 H5	E 6215-G	E9015-G	E6215-G

Characteristics and typical fields of application

Creep resistant. Basic covered medium alloyed electrode for the welding of similar creep resistant materials. Good welding characteristics even in out-of-position welding.

Field of use is the welding of creep resistant steels in boiler, tank and pipeline construction and reactor fabrication.

Base materials

HCM2S; Grade T23 (ASTM A213); Grade P23 (ASTM A335);
7CrWVMoNb9-6 (EN 10216-2)

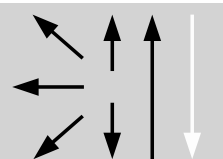
Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn	Cr	W	V	Nb
wt-%	0.06	0.2	0.5	2.2	1.7	0.22	0.04

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
740 °C / 2 h	540	620	19	130

Operating data

	Polarity: DC (+)	Redrying: 300 – 350 °C / 2 h (572 – 662 °F).	ø (mm) 2.5 3.2	L mm 250 350	Amps A 70 – 100 100 – 145
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Welding instruction

Materials	Preheating	Postweld heat treatment
180 – 220 °C / 200 – 280 °C	RT	740 °C / 2 h

Approvals

TÜV (10272), CE