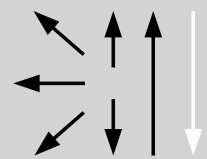


Classifications							
EN ISO 3580-A		EN ISO 3580-B		AWS A5.5		AWS A5.5M	
E Z CrMo2VNb B 4 2 H5		E 6215-2C1MV		E9015-G		E6215-G	
Characteristics and typical fields of application							
Creep resistant. Basic covered medium alloyed electrode for the welding of similar creep resistant materials. Good welding characteristics even in out-of-postion welding.							
Field of use is the welding of creep resistant steels in boiler, tank and pipe construction and reactor fabrication.							
Base materials							
1.7378 – 7CrMoVTiB10-10; T/P24							
Typical analysis of all-weld metal (wt.-%)							
	C	Si	Mn	Cr	Mo	V	Nb/Ti
wt-%	0.1	0.2	0.5	2.4	1.0	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)	L mm	Amps A
					2.5	250	70 – 100
					3.2	350	100 – 145
					4.0	350	140 – 190
Welding instruction							
Materials			Preheating		Postweld heat treatment		
200 – 220 °C / 200 – 280 °C			RT		740 °C / 2 h		
Approvals							
TÜV (10156), CE							