

## Classifications

<b>EN ISO 3580-A</b>	<b>AWS A5.5 / SFA-5.5</b>
E CrMo1 B 4 2 H5	E8018-B2 H4

## Characteristics and typical fields of application

Basic covered CrMo alloyed electrode. Cryogenic, suitable for quenching and tempering; resistant to caustic cracking; creep resistant in short time range up to 500 °C and in long time range up to 570°C. Electrode for heavy-duty steam boiler and superheater tube fabrication; for quenched and tempered steels.

## Base materials

13CrMo4-5, G22CrMo5-4


## Typical analysis

	C	Si	Mn	Cr	Mo	P	Sb	Sn	As
wt.-%	0.06	0.25	0.85	1.20	0.50	<0.012	<0.005	<0.005	<0.010

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

Condition	Yield strength	Tensile strength	Elongation A	Impact energy ISO-V KV J		
	R <sub>p0.2</sub>	R <sub>m</sub>	(L <sub>0</sub> =5d <sub>0</sub> )	20°C	-20°C	-40°C
	MPa	MPa	%			
s (690°C / 10h)	480 (≥ 460)	575 (≥ 550)	22 (≥ 20)	120	100	60
s + step cooling	460	550	22	120	100	50

## Operating data

	Polarity	DC+	Dimension mm	Current A
	Redrying	300 – 350°C / 2 h		2.5 × 350
			3.2 × 350	100 - 150
			3.2 × 450	100 - 150
			4.0 × 350	140 - 200
			4.0 × 450	140 - 200
			5.0 × 450	170 - 250

## Approvals

TÜV (01752.), CE