



AWS/ASME SFA-٥,٥ E ٧٠١٨-B٢L-H٤
DIN ٨٥٧٥ E CrMo ١ B ٢٠+
EN ١٥٩٩ E CrMo ١ B ٤٢ H ١٠

Application/properties:

This basic electrode with low carbon weld metal is suitable for welding creep resistant steels (pressure vessels, boilers and pipes) up to ٥٧٠°C. Heat treatment will be based on the base metal.

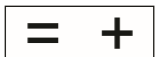
Weld metal analysis in % (typical values):

C	Si	Mn	Cr	Mo
< ٠,٠٥	٠,٤٥	٠,٨٠	١,١	٠,٤٥

Mechanical Properties of all-weld metal:

Heat treatment	Tensile Strength (N/mm ^٢)	Yield Strength (N/mm ^٢)	Elongation A _٤ , (%)	Impact energy (J) ISO-V
				+٢٠°C
١ h at ٦٩٠°C	> ٥٥٠	> ٤٦٠	٢٢	١٥٠

Welding Parameters		
Diameter (mm)	Length (mm)	Amperage (A)
٢.٥	٣٥٠	٦٠ - ٨٥
٣.٢٥	٤٥٠	١٠٠ - ١٣٠
٤.٠	٤٥٠	١٤٠ - ١٨٠
٥.٠	٤٥٠	١٩٠ - ٢٣٠



Materials:

DIN Standard ١٣CrMo ٤-٤; ١٨CrMo ٥; ١٦CrMo ٤-٤; ٢٨CrMo ٤; ٣٤CrMo ٥; GS-٢٢CrMo ٥-٤; GS-١٧CrMo ٥-٥

EN Standard ١٣CrMo ٤-٥; ١٨CrMo ٥; ١٦CrMo ٤; ١٦CrMoV٤; ٢٨CrMo ٤; ٣٤CrMo ٥; G٢٢CrMo ٥-٤; G١٧CrMo ٥-٥

ASTM Standard A١٩٣ Gr. B٧; A٣٣٥ Gr. P١١ a. P١٢; A٢١٧ Gr. WC٦

Remarks:

- Just Consume Dry Electrode
- Rebaking: required on ٣٠٠°C to ٣٥٠°C for ٢ hours.