

CARBO NiMo B

International standards	EN 757	E 62 4 Mn1NiMo B 42 H5
	AWS A 5.5	E 9018-G / E 10018-G

Approvals ---

Typical applications and characteristics CARBO NiMo B is a basic coated electrode for welding high-strength tempered steels as well AISI 4130 (similar 25CrMo4) as process welding on steels of corresponding strength. Due to its low hydrogen content (< 5ml / 100g), the weld metal is extremely crack-proof. Store in a dry place and rebake before use. Preheating and intermediate layer temperature acc. to the instructions of the base metal manufacturer.

Base materials 25CrMo4, AISI 4130, S 420- S 620 (StE 420- StE 620) u.ä. 15NiCuMoNb5 (1.6368)

Mechanical properties of all-weld metal (typical values)	Tensile strength R_m N/mm ²	Yield strength $R_{p0,2}$ N/mm ²	Elongation A_5 %	Impact energy ISO – V J - 40° C
	> 640	> 620	> 20	60

Weld metal analysis (typical, wt %)	C	Si	Mn	Ni	Cr	Mo	Cu
	0,10	0,4	1,2	0,9	0,1	0,35	0,05

Current = +

Welding positions PA, PB, PC, PD, PE, PF

Rebaking 1 h, 350 °C + / - 10 °C

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2.5 x 350	60 - 100	234	935	21.4	5.0	20.0
3.2 x 350	90 - 140	138	552	36.2	5.0	20.0
4.0 x 350	110 - 190	91	364	54.9	5.0	20.0
5.0 x 450	180 - 240	54	218	110.2	6.0	24.0

Rev. 000