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| International standards | DIN EN ISO 3580-A | E CrMoV1 B 42 H5 |
| | AWS A 5.5 | E9018-G |

Approvals ---

Typical applications and characteristics Basic coated CrMo alloy electrode for welding high-strength joints on low alloy tempered steels.
 Resistant to high temperatures up to 550°C.
 The electrode should be welded with a short arc, preferably on the + pole; for root layers weld on the – pole with an air gap.
 Preheating and post weld heat treatment of base materials to be carried out acc. to the steel manufacturer's instructions.

Operating temperature Room temperature up to + 550° C

Base materials 1.7706 G17CrMoV5-10 1.7357 G17CrMo5-5
 1.7745 15CrMoV5-10
 1.7733 24CrMoV5-5

| | | | | | |
|---|---|--|---------------------------------------|-----------------------------------|--------------------------|
| Mechanical properties of all-weld metal (typical values) | Tensile strength R _m N/mm ² | Yield strength R _{eL} N/mm ² | Elongation A ₅ % | Impact strength ISO-V J | 1 Annealed 30 min. 720°C |
| | 650 | 440 | >15 | 50 | |

| | | | | | | |
|--|----------|-----------|-----------|-----------|-----------|----------|
| Weld metal analysis (typical, wt %) | C | Si | Mn | Cr | Mo | V |
| | 0,08 | 0,4 | 0,9 | 1,1 | 1,0 | 0,3 |

Current = +(-) / ~ 65 V

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

Rebaking 1 h. 350 °C + / - 10 °C (if necessary)

| Dia./Length | Amperage (A) | Pcs./packet | Pcs./carton | kg / 1000 | kg / packet | kg / carton |
|-------------|--------------|-------------|-------------|-----------|-------------|-------------|
| 2,5 x 350 | 70 - 110 | 234 | 935 | 21,4 | 5,0 | 20,0 |
| 3,2 x 350 | 95 - 150 | 138 | 552 | 36,2 | 5,0 | 20,0 |
| 4,0 x 350 | 130 - 190 | 91 | 364 | 54,9 | 5,0 | 20,0 |
| 5,0 x 450 | 150 - 240 | 54 | 218 | 110,2 | 6,0 | 24,0 |

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