

## CARBO CrMo 2 AC

International standards		Materia	al No.		1	7384				
			N 3580-	A		CrMo2	R 12	2		
		AWS A				9013-0				
Approvals										
Typical applic and character		AC-weldable CrMo alloy electrode for welding high-strength joints on tempered steels up to 1100 N/mm <sup>2</sup> . Suitable for welding creep-resistant CrMo steels in boiler and piping sys- tem construction. Resistant to high temperatures up to 500°C. Non-ageing welding deposit, resistant to alkaline solutions, heat treatable and case- harden able. Preheating and post weld heat treatment of base materials to be carried out acc. to the steel manufacturer's instructions.								
Operating terr	Room temperature up to + 500 °C									
Base material	1.738010CrMo9-101.725926CrMo71.737512CrMo9-101.727324CrMo101.7380GS-12 CrMo 9 101.727610CrMo111.7379GS-18 CrMo 9 101.728116CrMo9-31.807510CrSiMoV710CrSiMoV710CrSiMoV7									
Mechanical properties of all-weld metal ( typical values)		Tensile strength R <sub>m</sub> N/mm²		Yield strength R <sub>eL</sub> N/mm²				Impact energy ISO–V + 20°C	, J	
		650		510		22		80		
Weld metal analysis		С	Si	Μ		Cr	Мо			
(typical, wt %)		0.05	0.6	1.	0	2.3	1.0	)		
Current		= - ~ / 65 V								
Welding positions		PA, PB, PC, PD, PE, PF,								
Rebaking1 h, 350 °C + / - 10 °C( if necessary)										
Dia./Length Ampera		e (A)	A) Pcs./ packe		Pcs./ carton		n kg	g / 1000	kg / packet	kg / carton
2.5 x 350	70 - 1	10				952		16,8	5.0	20.0

Dia./Length	Amperage (A)	PLS./ packet	FCS./ Carton	KY / 1000	κή γρασκεί	Ky / Carton
2.5 x 350	70 - 110	238	952	16,8	5.0	20.0
3.2 x 350	95 - 150	153	651	32,7	5.0	20.0
4.0 x 350	130 - 190	97	385	51,9	5.0	20.0
5.0 x 450	150 - 240	64	238	101,0	6.0	24.0
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Rev. 001/11

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.