

CARBO CrMo 5 B

International standards	Material No.		1	1.7373					
	DIN EN ISO 3580-A		E	CrMo5 B 42					
	AWS A 5.5			E 8016-B6					
	AWS A 5.4			E 502-15					
Characteristics	Basic coated CrMo alloy electrode for welding joints with good mechanical properties to low alloyed quenched and subsequently tempered steels up to 1275 N/mm ² . Suitable for welding heat treatable, quenched and subsequently tempered steels as well as for tubes, resistant to caustic embrittlement for working temperatures up to 650°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 + 650 °C								
Base materials	1.7380 10CrMo9-101.7259 26CrMo71.7375 12CrMo9-101.7273 24CrMo101.7380 G-12CrMo9-101.7276 10CrMo111.7379 G-17CrMo9-101.7281 16CrMo9-31.8075 10CrSiMoV71.7362 X12CrMo5								
Mechanical properties of all-weld metal (typical values)	Tensile strength Rm N/mm²	Yield strength ReL N/mm²	Elongation A5 %	Impact energ ISO.V J + 20°C	760°C 2. Tempered	1. Annealed 30 min.at 760°C 2. Tempered 30 min. at 950°C, then 30 min. at 760°C			
	620	490	>17	>70		1.			
	600	500	>17	>80		2.			
]			
Weld metal analysis	С	Si	Mn	Cr	Мо				
(typical, wt. %)	0,06	0,5	1,0	5,1	0,5				
Current $= + (-) \sim / 65 V$ Welding positionsPA, PB, PC, PD, PE, PFRebaking1 h, 350° C + / - 10° C (if required)									
Dia./Length Amperage (A)	Pcs. / packet	Pcs. / ca	rton k	g / 1000	kg / packet	kg / carton			

Dia./Length	Amperage (A)	Pcs. / packet	Pcs. / carton	kg / 1000	kg / packet	kg / carton
2,5 x 300	70 - 110	234	935	21,4	5,0	20,0
3,2 x 350	95 - 150	138	552	36,2	6,0	24,0
4,0 x 450	130 -190	91	364	54,9	6,0	24,0
5,0 x 450	150 - 240	54	218	110,2	6,0	24,0

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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.