

## CARBO CrMo 5 B

### International standards

Material No.	1.7373
DIN EN ISO 3580-A	E CrMo5 B 42 H5
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<sup>2</sup>. 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 10CrMo9-10	1.7259 26CrMo7
1.7375 12CrMo9-10	1.7273 24CrMo10
1.7380 G-12CrMo9-10	1.7276 10CrMo11
1.7379 G-17CrMo9-10	1.7281 16CrMo9-3
1.8075 10CrSiMoV7	1.7362 X12CrMo5

### Mechanical properties of all-weld metal ( typical values)

Tensile strength Rm N/mm <sup>2</sup>	Yield strength ReL N/mm <sup>2</sup>	Elongation A5 %	Impact energy ISO.V J + 20°C	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 (typical, wt. %)

C	Si	Mn	Cr	Mo
0,06	0,5	1,0	5,1	0,5

### Current

= + (-)~ / 65 V

### Welding positions

PA, PB, PC, PD, PE, PF

### Rebaking

1 h, 350° C + / - 10° C ( if required )

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