



# CrMo9 E

AWS A5.23: E8016-B8  
EN ISO 3580-A E CrMo9 B 42 H5

## DESCRIPTION

Low hydrogen basic coated electrode for welding of CrMo-alloyed high temperature steels and with similar composition. Used for high temperature and creep applications up to 600°C. Highly resistant to steam and hot gas. Suitable for thermoelectrical power plants, turbine rotors, petrochemical plants, steam boilers etc.

### WELDING POSITIONS



### POLARITY

DC+

### COATING

Basic

## BASE MATERIALS

X12CrMo9-1; A335: (Gr P9, F9, T9), GX 12CrMo10-1; A217 C12, 1.7386

## MECHANICAL PROPERTIES

<i>R<sub>m</sub></i> (Mpa)	<i>R<sub>p 0,2</sub></i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
>650	>500	>19	>60 J (+20° C)

## WELD METAL COMPOSITION(%)

C	Si	Mn	Mo	Cr	Cu	Ni
0,1	0,4	0,8	1,0	9,0	-	-
Al	V	N	Nb			
-	-	-	-			

## PACKAGING

Dimension(mm)	2,5x350	3,2x350	4,0x350	
Box(kg)	4/12	5/15	5/15	
Ampere(A)	80	115	150	

## EQUIVALENT FILLER METALS

MAG	Meltolit SGCrMo91 Mag
TIG	Meltolit SGCrMo91 Tig

Pre heating is recommended to 250-350°C. Interpass temperature 205-320°C. Post welding heat treatment 750°C for one hour and slow cooling.