CrMo5 E

AWS A5.5: E8018-B ISO 3580-A: E CrMo5 B 42 H5

DESCRIPTION

Low hydrogen basic coated electrode alloyed with Cr and Mo for welding creep resistant steels with 5,0%Cr – 0,5% Mo. Resistant to high temperature up to 600°C. Highly resistant to hot gas and overheated steam.For heat exchangers, tubes, steam boilers, overheaters.

WELDING POSITIONS	POLARITY	COATING
	DC+	Basic

MATERIAL

Creep resistant steels

MECHANICAL ANALYSIS

Rm (Mpa)	*Rp 0,2 (Mpa)*	*A5 (%)*	*KV(j)*
>590	>420	>20	+20ºC >70

CHEMICAL ANALYSIS(%)

C	Mn	Si	Cr	Mo
0.07	0,8	0,4	2,25	1,0

PACKING INFORMATION AND WELDING CURRENT

Dimension	2,5 x 350	3,2 x 350	4,0 x 450	5,0 x 450
Kg/pack	5	6	6	6
Ampere(A)	80	115	150	190

EQUIVALENT CONSUMABLES

TIG	Meltolit SGCrMo5 Tig
MAG	Meltolit SGCrMo5 Mag

Re-drying if necessary for one hour in 300°C. Pre heating of joints at 300°C. Interpass temp 250-350°C. Annealing after welding is advised at 730°C, then slow cooling.