

Classifications

EN ISO 3580-A	EN ISO 3580-B	WS A5.5 / SFA-5.5	AWS A5.5M
E CrMo2 B 4 2 H5	E 6215-2C1M	E9015-B3 H4	E6215-B3

Characteristics and typical fields of application

CrMo core wire alloyed, basic coated stick electrode.

Extra low content of trace elements; step-cooling tested; not sensitive to long term embrittlement. Manufacture of chemical apparatus, hydrocrackers; for welding work on heavy-duty boilers, superheaters, superheater lines; for welding of CrMo and CrMoV alloyed steels for the petrochemical industry.

Base materials

10 CrMo 9-10, 12 CrMo 9-10, 10 CrSiMoV 7, 15 CrMoV 5-10; ASTM A335 Gr. P22, A217 Gr. WC9

Typical analysis

	C	Si	Mn	Cr	Mo	S	P	Sb	Sn	As
wt.-%	0.07	0.22	0.75	2.2	0.9	≤ 0.010	≤ 0.012	≤ 0.005	≤ 0.005	≤ 0.010


Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength	Tensile strength	Elongation A	Impact values ISO-V KV J		
	$R_{p0.2}$	R_m	$(L_0=5d_0)$	20°C	-30°C	-40°C
	MPa	MPa	%			
a	560 (≥ 530)	670 (≥ 620)	22 (≥ 18)	180 (≥ 47)	140	140
s	440	550	≥ 18	130 (≥ 47)	80	60

a annealed 690 °C/1h

s annealed 690 °C/1h + step cooling

Operating data

	Polarity	DC (+)	Dimension mm	Current A
	Redrying	300 – 350°C/2h		
			2.5 × 250	70 - 100
			3.2 × 350	100 - 145
			3.2 × 450	100 - 145
			4.0 × 350	140 - 190
			4.0 × 450	140 - 190
			5.0 × 450	160 - 240

Approvals

TÜV (01823), CE