

Standards

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| TS EN ISO 3580-A | : E CrMo2L B 42 H5 |
| EN ISO 3580-A | : E CrMo2L B 42 H5 |
| AWS A5.5 | : E 8018-B3 L H4 |

**Chemical Composition of
Weld Metal % (Typical)**

| C | Si | Mn | Mo | Cr |
|------|-----|-----|-----|-----|
| 0.04 | 0.6 | 0.6 | 1.1 | 2.2 |

Mechanical Properties

| Yield Strength (N/mm ²) | Tensile Strength (N/mm ²) | Impact Strength (ISO-V/+20°C) | Elongation (L ₀ =5d ₀) (%) | Heat Treatment |
|--|--|----------------------------------|--|----------------------------------|
| min. 530 | min. 620 | min. 47 J | min. 18 | 690-750 °C / 1h / 300°C (air) |

Typical Base Material Grades

- 2% Cr - 1% Mo Steels, A335 Gr. P22

Features and Applications

- Applicability in welding of heat-resisting steels containing 2% Cr - 1% Mn and similar alloys
- Electrode with basic-type coating
- Formation of more ductile and less hard weld metal due to low carbon content
- Serviceability at temperatures of values up to 600 °C
- Recommended pre-heating and post-heat treatment during welding processes
- Requirement of re-drying for min. 2 hours at the temperatures between 300°C and 350°C

Welding Positions

Current Type

D.C.(+)

Operating Data

| Product Code | Diameter x Length (mm) / (inch) | | Welding Current (A) | Weight g / 100 pcs |
|--------------|------------------------------------|-------------|------------------------|-----------------------|
| 3010100825 | 2.50 x 350 | 3/32 x 14" | 80 - 110 | 2100 |
| 3010100828 | 3.20 x 350 | 1/8 x 14" | 100 - 140 | 3480 |
| 3010100831 | 4.00 x 450 | 5/32 x 18 " | 130 - 180 | 6680 |

Approvals: GOST-R, CE, SEPRO