

Standards

TS EN ISO 3580-A	: E CrMo2 B 42 H5
EN ISO 3580-A	: E CrMo2 B 42 H5
AWS A5.5	: E 9018-B3 H4

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

C	Si	Mn	Mo	Cr
0.07	0.4	0.8	1.0	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

- 10CrMo9-10, 10CrSiMoV7, G-18CrMo9-10, A335 Gr. P22

Features and Applications

- Welding of steam boilers, steam pipes made of Cr-Mo-alloyed steels, nitrided steels, not-heat treated cementation steels
- Resistance of weld metal to working temperatures up to 600°C
- 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
3010100801	2.50 x 350	3/32 x 14"	80 - 110	2280
3010100804	3.20 x 350	1/8 x 14"	100 - 140	3490
3010100810	4.00 x 450	5/32 x 18"	130 - 180	6860
3010100813	5.00 x 450	3/16 x 18"	190 - 240	10010

Approvals: CE, SEPRO