

Standards

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: CE, SEPRO