

Standards

TS EN ISO 3580-A	: E CrMo5 B 42 H5
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AWS A5.5 (A5.4)	: E 8018-B6 (E 502-15) H4

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Mo	Cr
0.06	0.4	0.8	0.5	5.2

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. 460	min. 590	min. 47 J	min. 19	730-755°C / 1h / 300°C (air)

Typical Base Material Grades

- X12CrMo5, GX12CrMo5

Features and Applications

- High-heat-resistant steels
- In petro chemical industry and on pressured-hydrogen tanks
- Serviceability of weld metal at working temperature up to 650°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
3010100834	2.50 x 350	3/32 x 14"	65 - 90	2220
3010100837	3.20 x 350	1/8 x 14"	110 - 130	3630
3010100843	4.00 x 450	5/32 x 18"	140 - 180	6670
3010100846	5.00 x 450	3/16 x 18"	190 - 240	10000

Approvals: CE, SEPRO