OPUS 9 CM-15

Standards

TS EN ISO 3580-A	: E CrMo9 B 42 H5
EN ISO 3580-A	: E CrMo9 B 42 H5
AWS A5.5	: E 8015-B8 H4

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Mo	Cr
0.07	0.4	0.8	1.0	9.0

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. 34 J	min. 19	740-780 °C / 2h / 300 °C (air)

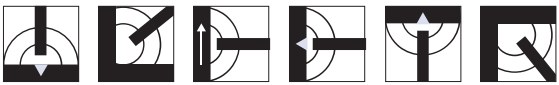
Typical Base Material Grades

- X12CrMo9-1, X7CrMo9-1, A335 Gr. P9

Features and Applications

- Heat resistance and low hydrogen electrode with basic-type coating
- Resistance of weld metal to working temperatures up to 650°C
- Welding of pressurized boiler steels, pipe steel and steel castings
- 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
3010100858	3.20 x 350	1/8 x 14”	90 - 130	3800
3010100861	4.00 x 350	5/32 x 14”	120 - 160	5200

Approvals: CE, SEPRO