

Standards

TS EN ISO 3580-A	: E CrMo9 B 4 2 H5
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AWS A5.5	: E 8018-B8 H4
AWS A5.4	: E 505-15

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

C	Si	Mn	Mo	Cr
0.07	0.4	0.7	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, GX12CrMo10.

Features and Applications

- Welding of boilers, pressure vessel steels, pipe steels and cast steels
- Electrode coating of basic character
- Electrode content of wt% 9 Chromium wt% 1 Molybdenum
- Serviceability at temperatures of values 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
3010100849	2.50 x 350	3/32 x 14"	60 - 90	2330
3010100852	3.20 x 350	1/8 x 14"	90 - 130	3810
3010100855	4.00 x 450	5/32 x 18"	120 - 160	6680

Approvals: CE, SEPRO