

Standards

TS EN ISO 3580-A	: E CrMo1 B 42 H5
EN ISO 3580-A	: E CrMo1 B 42 H5
AWS A5.5	: E 8015-B2 H4

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

C	Si	Mn	Mo	Cr
0.07	0.5	0.8	0.5	1.1

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	580 - 740	min. 47 J	min. 20	690°C / 1h / 300°C (air)

Typical Base Material Grades

- 13CrMo4-5, 15CrMo5, 16CrMoV4, G17CrMo5-5, GS22Mo4, G22CrMo5-4, A193 Gr.B7, A335 Gr.P11,

Features and Applications

- Welding of steam boilers and steam pipes made of Cr-Mo alloyed heat resistant steels, cementation steels, nitrided steels
- Resistance of weld metal to operating temperatures of values up to 570°C.
- Weld metal recovery of approx. 125%
- It can be used in position welding with lower heat input
- Usable with short arc in (-) pole for root pass welding with excellent penetration
- Requirement of re-drying for minimum 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
3010100762	2.50 x 350	3/32 x 14"	80 - 110	2190
3010100765	3.20 x 350	1/8 x 14"	100 - 140	3740
3010100771	4.00 x 450	5/32 x 18"	140 - 190	6750
3010100774	5.00 x 450	3/16 x 18"	190 - 240	10020

Approvals: CE, SEPRO