Standards

TS EN ISO 3580-A	: E CrMo1L B 4 2 H5
EN ISO 3580-A	: E CrMo1L B 4 2 H5
AWS A5.5	: E 7018-B2 L H4

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Mo	Cr
<0.05	0.6	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 ($L_0=5d_0$) (%)
min. 460	min. 550	min. 47 J	min. 20

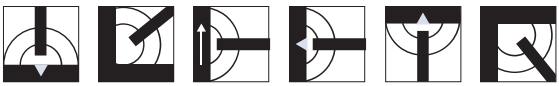
Typical Base Material Grades

- 13CrMo4-5, 15CrMo5, 16CrMoV4, G17CrMo5-5, GS-22Mo4, GS-22 CrMo5-4, A 193 Gr B7, A335 Gr P11, P12

Features and Applications

- Applicability in welding heat-resisting, low-alloyed steels
- Suitability to use against corrosion in sour crude, and against stress corrosion in petrochemical industry
- 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
3010100777	2.50 x 350	3/32 x 14”	80 - 110	2220
3010100780	3.20 x 350	1/8 x 14”	100 - 140	3520
3010100783	4.00 x 450	5/32 x 18”	140 - 190	6790
3010100786	5.00 x 450	3/16 x 18”	190 - 240	10020

Approvals: CE, SEPRO