

**Standards:**

EN ISO 3580-A: E Cr Mo 2 B 42  
 (EN 1599): E Cr Mo 2 B 42  
 AWS A 5.5: ~E 9018-B 3  
 Mat.-No.: 1.7384

# capilla<sup>®</sup> CrMo 2 B

**Product description:**

Basic coated stick electrode suitable for fusion welding of boiler and tube steels as well as similar CrMo-alloyed, hydrogen pressure resistant steels at service temperatures up to 550°C. Additionally suitable for fusion and overlay welding of similar alloyed hardened and tempered steels.

**Applications:**

For fusion welding of steel grades as follows:

Boiler steels: 10 CrMo 9-10,  
 11 CrMo 9-10.  
 Steel casts: GS 17 CrMo 9-10.

**Typical weld metal composition:**

[wt. - %]

	C	Mn	Si	Cr	Mo	Fe
Min.						
Max.	0,08	0,9	0,3	2,2	1,0	Bal.

**Mechanical properties:**

(without heat treatment; minimum values at ambient temperature)

Tensile strength $R_m$ :	550	[MPa]
Yield strength $R_{p0,2}$ :	440	[MPa]
Yield strength $R_{p1,0}$ :	-	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	100	[J]

Positions: all except PG

Redrying: 300°C/2h

**Dimension:**

Ø [mm]	Length [mm]	Welding current [A]
2,0	300	50 – 70
2,5	350	70 – 90
3,25	350/450	115 – 135
4,0	450	150 – 175
5,0	450	190 – 240

Polarity  
 =(+)~

**also available:**

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Capilla SG CrMo 2 MAG  
 Capilla SG CrMo 2 WIG