

Standards:

EN ISO 3580-A: E CrMo 5 B 2 2
 (EN 1599): E CrMo 5 B 4 2
 AWS A5.5: E 8015-B6

capilla[®] CrMo 5 B

Product description:

CrMo-alloyed basic coated stick electrode suitable for welding of similar alloyed steel grades.

Applications:

Welding of heat resistant and high-pressure hydrogen resistant steels used in boilers, vessels and tubings.

Base material: 12 CrMo 19-5.

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Cr	Mo	Fe
Min.		0,5	0,5	5,5	0,6	
Max.	0,08	0,6	0,7	6,5	0,7	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	620	[MPa]
Yield strength $R_{p0,2}$:	490	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	19	[%]
Impact strength (ISO-V):	70	[J]

Positions: all except PG

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]
2,5	350	70 – 90
3,25	350	115 – 135
4,0	350/450	150 – 175
5,0	450	180 – 240

Polarity
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also available:

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SG CrMo 5 MAG
 SG CrMo 5 WIG