

E CrMo5

CATEGORY SMAW Stick Electrodes

TYPE Medium and high alloyed basic electrodes for welding creep resistant steels

APPLICATIONS Construction and maintenance of power stations, oil (crack plant) and chemical plants

PROPERTIES Cr and Mo-alloyed basic electrode for welding creep resistant steels and steel casting for working temperatures up to 600°C. The weld metal is resistant to high hydrogen pressure.

CLASSIFICATION	AWS	A 5.5: E 8016-B6
	EN ISO	3580-A: E CrMo5 B 42 H5
	DIN: W.Nr.	1.7373
	DIN	8575: E CrMo5 B 20+

SUITABLE FOR 12crmo19.5, GS-12crmo19.5, 1.7362, 1.7363

APPROVALS CE Approved

WELDING POSITIONS:



FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Mn	Si	Cr	Mo
0.06	0.90	0.60	5.2	0.50

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				+20°C	-40°C	-60°C	
730°C / 2 hours	>490	580-740	>18	>70			

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current DC+	kg / can	kg / 6pack	kg / 1000
2.5	300	65-85	2.6	15.6	
3.2	350	100-130	2.6	15.6	
4.0	450	140-180	3.3	19.8	
5.0	450	180-230	3.3	19.8	

REDRYING TEMPERATURE 400C°/1h