

## 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 <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	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** 400°C/1h