

Classifications

EN ISO 3580-A	AWS A5.5
E Z CrMo2V B 4 2 H5	E9015-G

Characteristics and typical fields of application

Basic-coated CrMoV alloyed electrode. Extra low content of trace elements, thus insensitive to long term embrittlement.

Welding of thick walled pressure vessels made of CrMoV-steels for the petrochemical industry and in the oil and gas industry.

Step-cooling tested.

Base materials

2.5 Cr – 1 Mo – 0.25 V steels;

1.7703 – 13CrMoV9-10

ASTM SA 542 type D Cl. 4a; SA 832 Gr. 22V; SA 336 Gr. F22V; SA 541 Gr. 22V; SA 182 Gr. 22V

Typical analysis of all-weld metal

	C	Si	Mn	Cr	Mo	V	Nb
wt.-%	0.09	0.25	0.75	2.5	1.0	0.25	0.01

Mechanical properties of all-weld metal

Heat-treatment	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J			
	MPa	MPa	%	+20 °C	-20 °C	-30 °C	-40 °C
sr	540	670	18	140	100	70	55

(705 °C / 10 h)

Operating data

	Polarity: DC (+)	Ø mm	L mm	Amps A
		3.2	450	100 – 145
		4.0	350	140 – 190
		4.0	450	140 – 190
		5.0	450	160 – 240

Approvals

TÜV (10230.)