

International standards	EN 1599	E CrMoV1 B 42 H5
	DIN 8575	E CrMoV1 B 20+
	AWS A 5.5	E9018-G

Approvals ---

Typical applications and characteristics

Basic coated CrMo alloy electrode for welding high-strength joints on low alloy tempered steels.
 Resistant to high temperatures up to 550°C.
 The electrode should be welded with a short arc, preferably on the + pole; for root layers weld on the – pole with an air gap.
 Preheating and post weld heat treatment of base materials to be carried out acc. to the steel manufacturer's instructions.

Operating temperature Room temperature up to + 550° C

Base materials

1.7706	G17CrMoV5-10	1.7357	G17CrMo5-5
1.7745	15CrMoV5-10		
1.7733	24CrMoV5-5		

Mechanical properties of all-weld metal (typical values)	Tensile strength R _m N/mm ²	Yield strength R _{eL} N/mm ²	Elongation A ₅ %	Impact strength ISO-V J	1 Annealed 30 min. 720°C
	650	440	>15	50	

Weld metal analysis (typical, wt %)	C	Si	Mn	Cr	Mo	V
	0,08	0,4	0,9	1,1	1,0	0,3

Current = +(-) / ~ 65 V

Welding positions PA, PB, PC, PD, PE, PF,

Rebaking 1 h. 350 °C + / - 10 °C (if necessary)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	70 - 110	234	935	21,4	5,0	20,0
3,2 x 350	95 - 150	138	552	36,2	5,0	20,0
4,0 x 350	130 - 190	91	364	54,9	5,0	20,0
5,0 x 450	150 - 240	54	218	110,2	6,0	24,0

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.