

# CARBO CrMo 2 AC

International standards	Material No.	1.7384
	EN 1599	E CrMo2 R 12
	AWS A 5.5	E 9013-G

**Approvals** ---

**Typical applications and characteristics**

AC-weldable CrMo alloy electrode for welding high-strength joints on tempered steels up to 1100 N/mm<sup>2</sup>.  
Suitable for welding creep-resistant CrMo steels in boiler and piping system construction. Resistant to high temperatures up to 500°C.  
Non-ageing welding deposit, resistant to alkaline solutions, heat treatable and case- harden able.  
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 + 500 °C

Base materials	1.7380	10CrMo9-10	1.7259	26CrMo7
	1.7375	12CrMo9-10	1.7273	24CrMo10
	1.7380	GS-12 CrMo 9 10	1.7276	10CrMo11
	1.7379	GS-18 CrMo 9 10	1.7281	16CrMo9-3
	1.8075	10CrSiMoV7		

**Mechanical properties of all-weld metal**  
( typical values)

Tensile strength R <sub>m</sub> N/mm <sup>2</sup>	Yield strength R <sub>eL</sub> N/mm <sup>2</sup>	Elongation A <sub>5</sub> %	Impact energy ISO-V J + 20°C
650	510	22	80

**Weld metal analysis**  
(typical, wt %)

C	Si	Mn	Cr	Mo
0.05	0.6	1.0	2.3	1.0

**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	238	952	16,8	5.0	20.0
3.2 x 350	95 - 150	153	651	32,7	5.0	20.0
4.0 x 350	130 - 190	97	385	51,9	5.0	20.0
5.0 x 450	150 - 240	64	238	101,0	6.0	24.0

Rev. 000