

CARBO CrMo 9 B

International standards	EN 1599	E CrMo9 B 42 H5
	AWS A 5.4	E 505-15
	AWS A 5.5	E 8018-B8

Approvals ---

Typical applications and characteristics Basic coated CrMo alloy electrode for welding joints with good mechanical properties to low alloyed quenched and subsequently tempered steels. Suitable for welding heat treatable, quenched and subsequently tempered steels as well as for tubes, resistant to caustic embrittlement for working temperatures up to 600°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 + 600 °C

Base materials 1.7386 X12CrMo9-1
1.7389 GX12CrMo10-1

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 energy ISO-V J + 20°C	1. Annealed 30 min.at 720°C 2. Tempered 30 min. at 930°C, then 30 min. at 720°C
	730	610	19	70	1.
	730	600	25	100	2.

Weld metal analysis (typical, wt %)	C	Si	Mn	Cr	Mo	Ni
	0.07	0,3	0,7	9	1	0,2

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

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