

<b>International standards</b>	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

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

<b>Weld metal analysis (typical, wt %)</b>	<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Cr</b>	<b>Mo</b>	<b>V</b>
	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

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