CARBO WELD
SCHWEISSMATERIALIEN GMBH

CARBO CrMo 2 B

International standards

Material No.	1.7384
EN 1599	E CrMo2 B 12 H5
AWS A 5.5	E 9018-B3

Approvals ---

Typical applications and characteristics

Basic coated CrMo alloy electrode for welding high-strength joints on tempered steels up to 1100 N/mm².
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.
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 + 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_m N/mm²	**Yield strength R_{eL} N/mm²**	**Elongation A_5 %**	**Impact energy ISO–V J + 20°C**	1. Annealed 30 min.at 760°C 2. Tempered 30 min. at 950°C, then 30 min. at 760°C
650	510	22	80	1.
550	450	26	100	2.

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	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