

# CARBO CrMo 5 B

<b>International standards</b>	Material No.	1.7373
	EN 1599	E CrMo5 B 42 H5
	AWS A 5.5	E 8018-B6
	AWS A 5.4	E 502-15

**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 up to 1275 N/mm<sup>2</sup>. 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 + 500 °C

<b>Base materials</b>	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		

<b>Mechanical properties of all-weld metal</b> ( typical values)	<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 energy</b> 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
	620	490	> 17	> 70	1.
	600	500	> 17	> 80	2.

<b>Weld metal analysis</b> (typical, wt %)	<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Cr</b>	<b>Mo</b>
	0.06	0,5	1.0	5,1	0,5

**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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