

CARBO NiMoCr

International standards	EN 757	E 62 6 Mn2NiCrMo B 4 2 H5
	AWS A 5.5	E 10018-G H4 R
	AWS A 5.5	E 10018-M H4 R mod.

Approvals ---

Typical applications and characteristics CARBO NiMoCr is a basic coated electrode with high ductility and crack resistance for high-strength tempered fine grained constructional steels as well as process welding on steel castings cast steels of corresponding strength. Due to its low hydrogen content (< 5ml / 100g), the weld metal is extremely crack-proof. Store in a dry place and rebake before use. Weld stringer beads, as thin as possible, with a short arc. Preheating and intermediate layer temperature acc. to the instructions of the base metal manufacturer.

Operating temperature - 60 up to + 400 °C

Base materials S500N - S500NH - S500NL
Quenched steels up to 780 N/mm² tensile strength
Tempered fine grained steels up to 620 N/mm² yield strength

Mechanical properties of all-weld metal (typical values)	Tensile strength R _m N/mm ²	Yield strength R _{p0,2} N/mm ²	Elongation A ₅ %	Impact energy ISO – V J	
	750	700	22	+ 20°C	-60°C
				140	> 47

Weld metal analysis (typical, wt %)	C	Si	Mn	Ni	Cr	Mo
	0.05	0.4	1.6	1,9	0.3	0.3

Current = +

Welding positions PA, PB, PC, PD, PE, PF

Rebaking 1 h, 350 °C + / - 10 °C

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2.5 x 350	60 - 100	234	935	21.4	5.0	20.0
3.2 x 350	90 - 140	138	552	36.2	5.0	20.0
4.0 x 350	110 - 190	91	364	54.9	5.0	20.0
5.0 x 450	180 - 240	54	218	110.2	6.0	24.0

Rev. 000