

CARBO CrMo 9 B

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International standards	DIN EN ISO 3		E CrMo9 I	3 42 H	15	4				
	AWS A 5.4		E 505-15	5-15		_				
	AWS A 5.5		E 8018-B8	3						
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/mm²	Yield strength R _{eL} N/mm		i- ∣IS0	mpact energy O–V 、 ⊦ 20°C	J 2. Tempe at 9	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	C Si	Mn	Cr	Мо	Ni					
(typical, wt %)	0.07 0,3		9	1	0,2					
	0.07 0,0	0,1	5	I	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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Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.