

CARBO NiMoCr 90

International standards	EN 757	E 69 4 Mn2NiCrMo B T 42 H5				
	DIN 8529	EY 69 75 Mn2NiCrMo B				
	AWS A 5.5	E 11018-M				

Approvals

Base materials

Typical applications
and characteristicsCARBO NiMoCr 90 is a basic coated electrode for welding high-strength
tempered low-alloy 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 + 450 °C

StE 500 up to StE 690 V as well as N-A-XTRA 55 up to 70. S500N up to S690Q

Mechanical properties of all-weld metal (typical values)	Tensile strength R _m N/mm²		Yield strength R _{p0,2} N/mm²			Elongation A₅ %		Impact energy ISO – V J - 40°C - 60°C	
	830		> 730			> 18		> 47	> 28
Weld metal analysis (typical, wt %)	C 0.05	Si 0.3	Mn 1.7	Ni 2	Cr 0.4		Mo 0.4		
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

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.