CARBO WELD
SCHWEISSMATERIALIEN GMBH

CARBO CrMo 5 AC

International standards

Material No.	1.7373
DIN EN ISO 3580-A	E CrMo5 R 12
AWS A 5.5	E 8018
AWS A 5.4	E 502-16

Approvals ---

Typical applications and characteristics

AC-weldable CrMo alloy electrode for welding joints with good mechanical properties to low alloyed quenched and subsequently tempered steels up to 1275 N/mm².
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.
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
620	490	> 17	> 70	1.
600	500	> 17	> 80	2.

Weld metal analysis (typical, wt %)

C	Si	Mn	Cr	Mo
0.06	0,7	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	279	1117	17,9	5,0	20,0
3,2 x 350	95 - 150	166	662	30,2	5,0	20,0
4,0 x 350	130 - 190	109	437	45,8	5,0	20,0
5,0 x 450	150 - 240	65	261	92,0	6,0	24,0

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