

Signed by P-O Oskarsson	Approved by Tony Dray/Christos Skodras	Reg no EN004677	Cancelling EN002468	Reg date 2008-12-29	Page 1 (2)
----------------------------	---	--------------------	------------------------	------------------------	---------------

REASON FOR ISSUE

Classification up dated to EN ISO 3580-A

GENERAL

Application: All position electrode (max 0.05%C) with basic coating for welding creep resisting steels alloyed with 1.24%Cr/0.5%Mo. The electrode is also recommended for welding 0.9%Cr/0.5%Mo steel. The chemical composition of the weld guarantees a low sensitivity to solidification cracking.

Welding advice: Use a short arc with low travel speed. Preheat and interpass temperatures of 160-190 °C.

Polarity: DC+

Alloy Type: Low alloyed

Coating Type: Basic

Diff Hydrogen: <5.0 ml/100g

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.5 E7015-B2L
EN ISO 3580-A E CrMo1L B 2 2 H5

APPROVALS

BV C1M-Low C
VdTÜV 03919

CHEMICAL COMPOSITION

	All Weld Metal (%)	
	Min	Max
C		0.05
Si		0.45
Mn	0.50	0.90
P		0.015
S		0.015
Cr	1.00	1.40
Ni		0.29
Mo	0.45	0.65
Nb		0.009
Cu		0.10
Sn		0.02
Pb		0.01
As		0.01
Sb		0.01

Signed by P-O Oskarsson	Approved by Tony Dray/Christos Skodras	Reg no EN004677	Cancelling EN002468	Reg date 2008-12-29	Page 2 (2)
----------------------------	---	--------------------	------------------------	------------------------	---------------

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	ISO	AWS
	PWHT 690°C 1h	PWHT 690°C 1h
	Min	Min
Rp0.2 (MPa)		390
ReL (MPa)	355	
Rm (MPa)	510	520
A4 (%)		19
A5 (%)	20	
Charpy V at 20°C (J)	47	

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	N	B	H	T	U
	Min	Max							
\varnothing x Length									
2.5 x 350	65	95	2.2	100	0.59	76.9	0.7	63	24
3.2 x 350	90	130	3.6	100	0.56	50.0	1.0	70	24
4.0 x 350	125	165	5.1	100	0.59	33.3	1.3	80	24
5.0 x 450	190	220	9.9	100	0.60	16.9	2.2	98	24

- W** = Weight (kg / 100 electrodes)
- η** = Efficiency (g weld metal x 100 / g core wire)
- N** = Effective value (kg weld metal / kg electrodes)
- B** = Changes (number of electrodes / kg weld metal)
- H** = Deposit rate at 90% of max current (kg weld metal / hour arc time)
- T** = Fusion time at 90% of max current (s / electrode)
- U** = Arc voltage (V)