

Classification

EN ISO 3580-A	AWS A5.5	AWS A5.5M
E ZCrWV2 1.5 B 4 2 H5	E9015-G	E6215-G

Characteristics and typical fields of application

Basic electrode core wire alloyed for welding bainitic steels such as P23/T23 (ASTM A 213, code case 2199), pipe material.

For high quality welds, which will provide reliable creep rupture properties for the whole service life of a boiler plant. Preheat and interpass temperature depends on wall thickness. PWHT at 740 °C for 2 h.

Base materials

HCM2S

ASTM A 182 Gr. F23; A 213 Gr. T23 (code case 2199); A335 Gr. P23;

Typical analysis of all-weld metal (wt.-%)

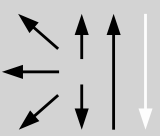
	C	Si	Mn	Cr	W	V	Nb
wt.-%	0.06	0.3	0.5	2.2	1.5	0.2	0.05

Mechanical properties of all-weld metal

Condition	Yield strength R _{p0,2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
a	≥ 530	≥ 620	≥ 17	≥ 47

a annealed 740 °C/2 h

Operating data

	Polarity:	Redrying if necessary:	Electrode identification:	∅ (mm)	L mm	Amps A
	DC (+)	300 – 350°C, min. 2 h	FOX P 23 9015-G E ZCrWV2 1.5 B	2.5	250	80 – 110
				3.2	350	100 – 140
				4.0	350	130 – 180

Preheat and interpass temperature depends on wall thickness.

Approvals

TÜV (10555.), CE