

Classification

EN ISO 3580-A	AWS A5.5	AWS A5.5M
E ZCrMo2VNb B 4 2 H5	E9015-G	E6215-G

Characteristics and typical fields of application

Basic core wire alloyed electrode for welding bainitic steels like 7CrMoVTiB10-10 (P24/T24 acc. To ASTM A 213 Draft).

For high quality welds, which will provide reliable creep rupture properties for the whole service life of a boiler plant. PWHT at 740 °C for 2 hrs.

Base materials

1.7378 7CrMoVTiB10-10
ASTM A 213 Gr. T24; A 182 Gr. F24

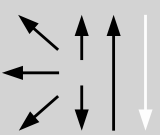
Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn	Cr	Mo	V	Nb
wt.-%	0.09	0.3	0.5	2.5	1.0	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 24 9015-G EZCrMo2VNbB	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 (10454.), CE