

## Classifications

EN 12536	AWS A5.2	AWS A5.2M
O V (mod.)	R65-G	RM45-G

## Characteristics and typical fields of application

CrMo-alloyed gas welding rod for high temperature boiler and tube steels equivalent to 13CrMo4-5 (1.25 % Cr 0.5 % Mo). Approved in long-term condition up to +500 °C service temperature.  
High viscous weld puddle.

## Base materials

High temperature steels same alloyed, steels resistant to caustic cracking  
1.7335 13CrMo4-5, 1.7262 15CrMo5, 1.7354 G22CrMo5-4, 1.7357 G17CrMo5-5, 1.7728 16CrMoV4,  
ASTM A 182 Gr. F12; A193 Gr. B7; A 213 Gr. T12; A 217 Gr. WC6; A 234 Gr. WP11; A335 Gr. P 11 u. P 12; A 336 Gr. F11, F12; A 426 Gr. CP12

## Typical analysis of the TIG rods (wt.-%)

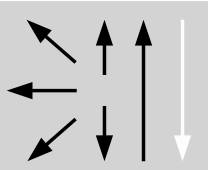
	C	Si	Mn	Cr	Mo
wt-%	0.12	0.1	0.8	1.2	0.5

## Mechanical properties of all-weld metal

Condition	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J
	MPa	MPa	%	+20 °C
a	≥ 315	≥ 490	≥ 18	≥ 47

a annealed, 680 °C, 2 h/ furnace down to 300 °C/ air

## Operating data

	Rod marking: front: ✦ O V (mod) back: R65-G	ø (mm)
		2.0
		2.5
		3.0

Wall thicknesses over 6 mm should be preheated to 100 – 200 °C and tempered at 660 – 700 °C for at least ½ hours followed by cooling in still air.

## Approvals

TÜV (1363.), SEPROZ, CE