

Standards:

EN ISO 3580-A: E Cr Mo 1 R 42
 (EN 1599): E Cr Mo 1 R 42
 AWS A 5.5: ~E 8018-B 2
 Mat.-No.: 1.7339

capilla® CrMo 1 Ti

Product description:

Rutile coated stick electrode suitable for fusion welding of boiler and tube steels as well as similar CrMo-alloyed, hydrogen pressure resistant steels at service temperatures up to 550°C.
 Additionally suitable for fusion and overlay welding of similar alloyed hardened and tempered steels.

Applications:

For fusion welding of steel grades as follows:

13 CrMo 4 4, GS-17 CrMo 5 5,
 16 CrMo 4 4, 25 CrMo 4,
 GS-25 CrMo 4, 22 CrMo 4 4,
 GS-22 CrMo 5 4, 42 CrMo 4

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Cr	Mo	Fe
Min.						
Max.	0,08	0,9	0,6	1,1	0,5	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R _m :	580	[MPa]
Yield strength R _{p0,2} :	490	[MPa]
Yield strength R _{p1,0} :	-	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	80	[J]

Positions: all except PG

Redrying: 300°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,0	300	50 – 70	=(+)~
2,5	350	70 – 90	
3,25	350/450	115 – 135	
4,0	450	150 – 175	
5,0	450	190 – 240	

also available:
 find in table of content

Capilla CrMo B
 Capilla SG CrMo 1 MAG
 Capilla SG CrMo 1 WIG