

Standards:

EN ISO 3580-A:
(EN 1599):
AWS A 5.5:
Mat.-No.:

E Cr Mo 2 B 42
E Cr Mo 2 B 42
~E 9018-B 3
1.7384

capilla® CrMo 2 B

Product description:

Basic 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:

Boiler steels: 10 CrMo 9-10,
11 CrMo 9-10.
Steel casts: GS 17 CrMo 9-10.

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Cr	Mo	Fe
Min.						
Max.	0,08	0,9	0,3	2,2	1,0	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R _m :	550	[MPa]
Yield strength R _{p0.2} :	440	[MPa]
Yield strength R _{p1.0} :	-	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	100	[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:

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Capilla SG CrMo 2 MAG
Capilla SG CrMo 2 WIG