

Standards:

EN ISO 2380-A:
(EN 1599):

EZ CrMo 3 V B 42
E CrMo 3 V B 42

capilla® CrMoV 3

Product description:

CrMoV-alloyed basic coated stick electrode suitable for welding of similar alloyed steel grades.

Applications:

Welding of heat resistant and high-pressure hydrogen resistant steels used in boilers, vessels and tubings.

Welding of CrMoV-alloyed steels used for oil processing applications.

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Cr	Mo	V	Fe
Min.		0,5	0,3	2,8	0,8	0,2	
Max.	0,09	0,6	0,5	3,5	1,1	0,3	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R _m :	510	[MPa]
Yield strength R _{p0,2} :	420	[MPa]
Yield strength R _{p1,0} :	-	[MPa]
Elongation (L=5d):	20	[%]
Impact strength (ISO-V):	60	[J]

Positions: all

Redrying: 320°C/2h

Dimension:

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