

Standards:

EN ISO 3580-A: E Mo B 22
 (EN 1599): E Mo B 22
 AWS A 5.5: E 7018-A1
 Mat.-No.: 1.5424

capilla® KB Mo**Product description:**

Basic coated stick electrode suitable for welding of boiler and tube steels. Mo-alloyed weld metal for service temperatures up to 550°C.

Applications:

For fusion welding of steel grades as follows:

16 Mo 3, GS-22 Mo4,
 17 Mn 4, 19 Mn 6, GS-C 25.

Typical weld metal composition:

[wt. - %]

	C	Mn	Si	Mo	Fe
Min.					
Max.	0,06	0,9	0,7	0,5	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	560	[MPa]
Yield strength $R_{p0,2}$:	480	[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 Mo MAG
 Capilla SG Mo WIG