

BASOWELD CrMo**ELECTRODES**
(SMAW)

SMAW electrodes for creep resistant steels

CLASSIFICATION:

EN ISO 3580-A: E CrMo1 B 42 H5
 DIN 8575: E CrMo1 B 20+
 AWS A-5.5: E 8018-B2

APPROVALS:

UDT

DESCRIPTION:

- Basic low hydrogen electrode with Cr and Mo.
- For welding heat-resistant and creep-resistant steels, working in temperatures up to 570°C.
- Weld metal resistant to sulfur, e.g. in crude oil at temperatures of 250-450 [°C]
- Resistant to hydrogen in some applications.
- Can be used for the production of pressure vessels for NH₃ up to 450 [°C]
- Electrode with very good primary and secondary ignition, stable, well focused arc.
- Low spatter and good slag release, crack resistant joint, creep resistance for the life of the joint.

BASE MATERIAL:

W.Nr	DIN	W.Nr	DIN
1.7335	13CrMo4-5	1.7339	11CrMo5-5
1.7214, 1.7218	25CrMo4	1.7262	15CrMo5
1.7131	16MnCr5	1.7258	24CrMo5
1.7128	GS-25CrMo4	1.7350	22CrMo4-4
1.7355	GS-17CrMo5-5	1.7225	42CrMo4
1.7015	15Cr3	1.7728	16CrMoV4
1.7147	20MnCr5	1.7354	GS-22CrMo5-4
1.7337	16CrMo4-4		

TYPICAL CHEMICAL COMPOSITION (%):

C 0,05 Si 0,40 Mn 0,75 Cr 1,10 Mo 0,50

TYPICAL MECHANICAL PROPERTIES:**Re:** >355N/mm²**Rm:** >510 N/mm²**A5:** >20%**Kv:** >47J (20°C)**Hardness:** Build-up weld app. 190[HB]

Preheating and interpass temperature minimum 200°C, for thicker elements up to 300°C. Maintain throughout welding and for some time after the process is complete.

Tempered bainite structure after heat treatment. Metal-to-metal wear resistant weld deposit and high impact strength.

Coating: basic**Redrying:** 300 - 350°C / 2 h**Heat treatment:** 680°C / 2h annealing, up to 300°C airing**Hydrogen content:** <5 ml/100 g

Post-weld heat treatment is required. Tempering at 660-700[°C]. Tempering time depends on the thickness of the element.

φ	Welding parameters		Packing		
	Length [mm]	Current [A]	Weight of packet [kg]	Weight of carton[kg]	Pcs/1 kg
2,5	350	65-95	4,0	12,0	48
3,2	350	100-130	4,0	12,0	27
4,0	450	140-180	5,5	16,5	15
5,0	450	180-230	5,5	16,5	10

RELATED PRODUCTS: RUTWELD CrMo, MIGWELD CrMo, TIGWELD CrMoRead more about this product: <https://www.metalweld.pl/en/basoweld-crmo>