

TECHNICAL INFORMATION

THYSSEN CHROMO 1

SMAW covered electrode for carbon- and low-alloyed steels

Classifications	DIN 8575	AWS A 5.5	EN
	E CrMo1 B 26	E 8018-B2	E CrMo1 B 42 H5

Characteristics and field of use Basic covered CrMo-alloyed electrode.

Good welding characteristics in out-of-position work; tough, crack-resistant weld metal suitable for normalizing and tempering; resistant to temperatures up to 500°C, as high as 570°C in the long-time range.

Redry for 2 h at 250 - 350°C.

Usable in heavy-duty steam boiler and superheater tube fabrication; specially suitable for high-temperature boiler steel 13 CrMo 44, for quenched and tempered steels.

Materials 13 CrMo 44, GS-22 CrMo 54

Typical weld analysis in %	C	Si	Mn	Cr	Mo
	0.06	0.30	0.90	1.00	0.50

Creep and stress rupture properties Roughly as per equivalent cast steel grades.

Mechanical properties of the weld metal acc. to DIN 32 525	Heat treatment	Yield strength N/mm²	Tensile strength N/mm²	Elongation (L₀=5D₀) %	Impact values CVN test J RT
		SR	>=490	>=580	22-30
	V	>=350	>=450	26-36	120-170

Welding Positions  **Polarity** = +

Approvals TÜV
Force

Packaging and amperages	Diam.	Length	pcs/pack	kg/pack	Ampere A
	2.5	300	225	4.6	70 – 110
	3.2	350	125	4.4	110 – 150
	4.0	350	100	5.3	140 – 200