TECHNICAL INFORMATION

THYSSEN CHROMO 2

SMAW covered electrode for carbon- and low-alloyed steels

Classifications

DIN 8575	AWS A 5.5	EN
E CrMo2 B 29	E 9015-B3	EC 4 Mo2 B 42 H5

Characteristics and field of use

Basic covered CrMo-alloyed electrode.

Extra low content of tramp elements; step-cooling-tested; largely insensitive to long-term embrittlement.

Manufacture of chemical apparatus, hydrocrackers; for welding work on heavy-duty boilers, superheaters, superheater lines; for welding CrMo and CrMo-V-alloyed steels for the oil industry.

Redry for 2 h at 300 - 350°C.

Materials

10 CrMo 910, 12 CrMo 910, 10 CrSiMo V 7, 15 CrMo V 510

Typical weld analysis in %

C	Si	Mn	Cr	Mo	P	As	Sb	Sn
0.07	0.25	0.70	2.20	0.90	<=0.01	<=0.01	<=0.00	<=0.00

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/mm^2	Tensile strength N/mm^2	Elongation ($L_0=5d_0$) %	Impact values CVN test J RT	-30°C	-40°C
SR	>=440	>=550	22-30	130-180	90-120	80-100
V	>=310	>=460	24-34	130-180		
S+step cooling	>=440	>=550	22-30	130-180	80-110	60-90

Welding Positions 

Polarity = +

Approvals

TÜV	CONTROLAS
TÜV Wein: corresp. to TÜV	Force

Packaging and amperages

Diam.	Length	kg/pack	Ampere A
2.5	250	3.2	70 – 100
3.2	350	4.2	100 – 145
4.0	350	4.5	140 – 190
5.0	450	5.9	160 - 240