

CROMOCORD 5L

TOP FEATURES

- Excellent tensile strength at high temperature, approved up to +650°C.
- The low carbon reduces the risk of cracking and promotes a lower tensile strength and hardness in the all weld metal deposit.
- Low diffusible hydrogen (HD<5ml/100g).

CLASSIFICATION

AWS A5.5 E8015-B6L H4
EN ISO 3580-A E CrMo5 B 22 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV

+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Cr	Mo
0.04	0.75	0.4	≤0.015	≤0.015	5	0.5

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
AWS A5.5	PWHT	≥460	≥550	≥19	not specified
EN ISO 3580-A	PWHT	≥400	≥590	≥17	≥47
Typical values	740°C x 2h	480	610	23	70

* PWHT: Postweld Heat Treatment 730-760°C / min 1h

Preheat and interpass temperature: 200-300°C

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	65-95
3.2 x 350	90-130
4.0 x 350	125-165

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	88	1.8	W100287697
3.2 x 350	VPMD	54	2.0	W100287698
4.0 x 350	VPMD	40	2.1	W100287699

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.