

CROMOCORD 92

TOP FEATURES

- The weld metal chemistry is low in impurity elements.
- Suitable for long term use, up to +650°C.
- Excellent operability in all position welding except vertical down.
- Stable arc with excellent bead shape and low spatter.
- Efficiency about 120%.
- Suitable for use with DC positive.

CLASSIFICATION

AWS A5.5 E 9018-G H4
EN ISO 3580-A E Z (CrMoWCoVNb9 0,5 2 1) B 42 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

CE

+

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

C	Mn	Si	P	S	Cr	Mo	Nb	Co	V	W	N
0.095	1.1	0.2	≤0.012	≤0.012	9	0.5	0.05	1.0	0.20	1.7	0.04

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
AWS A5.5	AW or PWHT	≥530	≥620	≥17	not specified
EN ISO 3580-A	AW or PWHT	not specified	not specified	not specified	not specified
Typical values	PWHT 760°C x 4h	560	640	19	65

AW: As-welded (preheat and interpass temperature as agreed between purchaser and supplier)

PWHT: Postweld Heat Treatment as agreed between purchaser and supplier

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	65-95
3.2 x 350	85-135
4.0 x 350	140-180

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	CBOX	195	4.2	W100258361
3.2 x 350	CBOX	110	4.2	W100258362
4.0 x 350	CBOX	70	4.0	W000258363
	CBOX	70	4.1	W100258363

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.