CROMOCORD KV3HR

TOP FEATURES

- The weld metal chemistry is low in impurity elements which allows to guarantee X-Factor <15ppm and J-Factor <150ppm
- Excellent tensile strength at high temperature, approved up to +600°C.
- Very low diffusible hydrogen (HD<4ml/100g).

CLASSIFICATION

AWS A5.5	E9018-B3 H4R
EN ISO 3580-A	E CrMo2 B 32 H5
EN ISO 3580-B	E 6218-2C1M H5

CURRENT TYPE

DC+/AC

WELDING POSITIONS

All position, except vertical down

APPROVALS

RINA	TÜV
+	+

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

C	Mn	Si	P	S	Cr	Mo	X-Factor
0.1	0.75	0.3	≤0.01	≤0.01	2.25	1	<12ppm

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -30°C
AWS A5.5	PWHT	≥530	≥620	≥17	not specified
EN ISO 3580-A	PWHT	≥530	≥620	≥15	not specified
Typical values	PWHT 690°C x 5h	560	660	27	140
	PWHT 690°C x 5h + STC	550	650	25	110
	PWHT 700°C x 1h	570	670	22	80

* PWHT: Postweld Heat Treatment as agreed between purchaser and supplier

STC = Step cooling

Preheat and interpass temperature as agreed between purchaser and supplier

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-95
3.2 x 350	90-130
4.0 x 350	125-165
4.0 x 450	125-165
5.0 x 450	170-220

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	80	1.9	W100380268
	CBOX	165	4.0	W100380267
3.2 x 350	VPMD	55	2.0	W100287654
	CBOX	115	4.2	W100287650
4.0 x 350	VPMD	40	2.1	W100287655
	CBOX	80	4.3	W100287651
4.0 x 450	VPMD	20	2.2	W100287656
	VPMD	40	2.8	W100380269
5.0 x 450	CBOX	50	5.4	W100287652

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.