CROMOCORD N125

TOP FEATURES

- Operating temperature <600°C.
- Very low diffusible hydrogen (HD<4ml/100g).
- Excellent radiographic and weldability in all position welding (except vertical down).

CLASSIFICATION

AWS A5.5	E9015-G H4
EN ISO 3580-A	E Z (CrMoV1) B 42 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	V
0.12	0.9	0.4	≤0.020	≤0.015	1.4	1.0	0.25

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-B	PWHT	≥530	≥620	≥15	not specified
Typical values	690°C x 8h / air	730	780	18	80

* PWHT: Postweld Heat Treatment 725-755°C / min 1h

AW: As-welded (preheat and interpass temperature: 160-190°C)

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-95
3.2 x 450	90-130
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
2.5x350	CBOX	TBD	0.0	W100258370
3.2x450	CBOX	TBD	0.0	W100258371
4.0x450	CBOX	TBD	0.0	W100258372
5.0x450	CBOX	TBD	0.0	W100258373

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.