CROMO E92

TOP FEATURES

- Basic coated MMA electrode made on matching core wire.
- Excellent tensile strength in creep regime.
- Good impact toughness down to 0°C.
- Low diffusible hydrogen (HD<4ml/100g).

CLASSIFICATION

AWS A5.5	E 9015-B92 H4
EN ISO 3580-B	E Z (CrMoWVNb9) B 42 H5

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV
+

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	B	Al	Cu
0.11	0.6	0.25	0.01	0.01	9	0.5	0.45	0.05	0.2	0.05	0.003	<0.01	<0.05

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/2h	630	740	19	60

* AW = As welded, PWHT = Post Weld Heat Treatment

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x300	70-85
3.2x350	90-120
4.0x350	125-155

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	CBOX	208	3.5	W100386549
3.2 x 350	CBOX	116	3.9	W100386550
4.0 x 350	CBOX	83	4.1	W100386551

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.