

Kryo® 1P

TOP FEATURES

- Excellent mechanical properties (impact down to -60°C)
- Good CTOD at -10°C
- Extremely low hydrogen content
- 112 - 120% recovery
- Weldable on AC and DC

CLASSIFICATION

AWS A5.5 E 8018-G-H4R
EN ISO 2560-A E 50 6 Mn1Ni B 32 H5

CURRENT TYPE

AC / DC (+/-)

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	BV	DNV/GL	TÜV	DB
+	+	+	+	+

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

C	Mn	Si	P	S	Ni	HDM
0.05	1.5	0.5	0.010	0.005	0.95	2 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					-40°C	-60°C
Required: AWS A5.5		min. 460	min. 550	min. 19	not specified	
EN ISO		min. 500	560-720	min. 18		min. 47
Typical values	AW	550	640	24	140	80
	SR:580°C/15h	460	550	24	150	90

AW = As welded; SR = Stress relieved

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x350	55-85
3.2x350	80-145
3.2x450	80-145
4.0x350	120-185
4.0x450	120-185
5.0x450	180-270

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Pieces / unit	Weight (kg)	Item number
2.5x350	SRP	70	1.3	519211-1
3.2x350	SRP	50	1.9	519181-1
3.2x450	SRP	50	2.4	519273-1
4.0x350	SRP	28	1.5	519198-1
4.0x450	SRP	28	2.0	519280-1
5.0x450	SRP	22	2.4	519204-1

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.