

Kryo® 4

TOP FEATURES

- Excellent impact toughness down to -80°C in as welded condition and -100°C after PWHT.
- Extremely low hydrogen content.

CLASSIFICATION

AWS A5.5 E7018-C2L H4R
EN ISO 2560-A E 42 6 3Ni B 32 H5

CURRENT TYPE

DC-

WELDING POSITIONS

All position, except vertical down

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

C	Mn	Si	P	S	Ni	HDM
0.04	0.8	0.4	0.01	0.005	3.3	3 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					-60°C	-80°C	-101°C
Required: AWS A5.5	PWHT**	min. 390	min. 480	min. 25			min. 27
EN ISO	AW	min. 380	470-600	min. 20	47		
Typical values	AW	490	570	30		90	
	PWHT**	420	510	30	120	90	70

*AW = As welded; PWHT = Post weld heat treatment

** 605±14 °C/1h

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	60-90
3.2 x 350	90-140
4.0 x 350	125-240

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	SRP	60	1.4	524970-1
3.2 x 350	SRP	48	1.8	524932-1
4.0 x 350	SRP	28	1.5	524949-1

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.