


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA SPEEDARC B CrMo1-E	
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CLASSIFICATION

ASME IIC SFA 5.5 / AWS A 5.5:	E8018-B2
EN ISO 3580-A:	E CrMo1 B 42 H5
ASME IX Qualification	QW-432 F-N° 4 QW-442 A-N° 3

DESCRIPTION

- Basic coated electrode
- 1,25Cr-0,5Mo deposit for elevated temperature service
- Service temperature up to 550°C
- Suitable for critical thick joints
- Complements Welding Alloys cored wires ROBOFIL M CrMo1 and ROBOFIL B CrMo1

APPLICATIONS

Welding creep-resisting steels of similar composition.
 Preheat at 150-250°C and post-weld heat treatment at 660-700°C must be carried out.

Examples

Creep resisting steel	1.7335, 1.7243, 1.7258, 1.7218, 1.7350, 1.7354 13CrMo45, 18CrMo4, 24CrMo5, 25CrMo4, 14CrMo45, 22CrMo44, G22CrMo54 A 182 Gr F11, F12; A 387 Gr 12, A213 / A 250 Gr T11; A335 Gr P11
Case hardening steel	DIN 17210 16MnCr5 ISO/TR 15608: Group 5.1

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo
0.06	0.8	0.4	1.1	0.5

MINIMUM ALL-WELD METAL PROPERTIES

P.W.H.T 1h / 700°C	Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
	550	460	19	+ 20°C: 120

TYPICAL ALL-WELD METAL PROPERTIES

P.W.H.T 1h / 700°C	Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
	640	560	24	+20°C: 160

OPERATING CONDITIONS

Electrode ØxL [mm]	2.5 x 350	3.2 x 450	4.0 x 450	5.0 x 450
Current [A]	70 - 90	110 - 145	130 - 170	160 - 220
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Re-baking before use: 1 hour at 300°C.

WELDING POSITIONS

EN ISO 6947:	PA, PB, PC, PF, PE
ASME IX:	1G, 2F, 2G, 3G, 4G

PACKAGING

Electrode ØxL [mm]	2.5x350	3.2x350	4.0x450	5.0x450
Weight/box [kg]	5			

Other packaging and other diameters: please consult us