


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA SPEEDARC B CrMo2-E	
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CLASSIFICATION

ASME IIC SFA 5.5 / AWS A 5.5:	E8018-B3
EN ISO 3580-A:	E CrMo2 B 42 H5
ASME IX Qualification	QW-432 F-N° 4 QW-442 A-N° 4

DESCRIPTION

- Basic coated electrode
- 2,25Cr-1Mo deposit for elevated temperature service
- Service temperature up to 600°C
- Suitable for critical thick joints
- Complements Welding Alloys cored wires ROBOFIL M CrMo2 and ROBOFIL B CrMo2

APPLICATIONS

Welding creep-resisting steels of similar composition.
Preheat at 250 - 300°C, maintain throughout welding cycle and some time after completion of welding.
Post-weld heat treatment at 660 - 700°C must be carried out with time being dependent on section thickness.

Examples

Creep resisting steel	EN 10028-2	10 CrMo 9-10
	EN 10222-2	12 CrMo 9-10
	ASTM A387gr .21 & 22, A182F22, A217WC9, A234WP22	
	ASTM A199, A200T3b, T4, T21, T22, A213T22	
	ISO/TR 15608: Group 5.2	

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo
0.07	0.8	0.4	2.25	1.0

MINIMUM ALL-WELD METAL PROPERTIES

	Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
P.W.H.T 1h / 700°C	570	450	17	+ 20°C: 47

TYPICAL ALL-WELD METAL PROPERTIES

	Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
P.W.H.T 1h / 700°C	670	570	20	+ 20°C: 120

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