

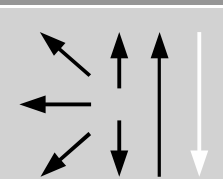
Classifications			
EN ISO 3580-A	EN ISO 3580-B	EN ISO 2560-A	EN ISO 2560-B
E Mo B 4 2	E 4918-G	E 50 4 Mo B 4 2	E 4918-G
AWS A5.5		AWS A5.5M	
E7018-G		E4918-G	

Characteristics and typical fields of application
Very good welding characteristics in out of position work; easy slag removal; cold toughness at temperatures as low as $-40\text{ }^{\circ}\text{C}$. High temperature resistant up to $500\text{ }^{\circ}\text{C}$ ($932\text{ }^{\circ}\text{F}$) and creep resistant up to $550\text{ }^{\circ}\text{C}$
Particularly suitable for circumferential welds in conduit pipes as well as boiler, pressure vessel, header and nuclear reactor fabrication.

Base materials
Fine grained structural steels S355N - S460N, P355NH - P460NH, P355NL1 - P460NL1; pipe steels L360NB - L415NB, L360MB - L485MB, X 52 - X 70; Boiler steels P235GH, P265GH, P295GH, 16 Mo 3, 20 MnMo 45, 16 Mo 5, 15 NiCuMoNb 5, 17 MnMoV 64; ASTM A 355 Gr. P1; A161-94 Gr. T1; A217 Gr. WC1; A182M Gr. F1; A204M Gr. A, B, C; A250M Gr. T1

Typical analysis of all-weld metal				
	C	Si	Mn	Mo
wt-%	0.06	0.35	1.2	0.45

Mechanical properties of all-weld metal					
Heat-treatment	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	-40 °C
aw	510 (≥ 500)	590 (560 – 720)	20	120	47
sr	520 (≥ 500)	600 (560 – 720)	21	120	47

Operating data					
	Polarity: DC (+)	Re-drying: 250 – 350 °C / 2 h	ø mm	L mm	Amps A
			2.5	350	70 – 110
			3.2	350	100 – 140
			4.0	350/450	140 – 190
5.0	450	180 – 250			

Approvals
TÜV (00902), DB (10.132.31), DNV GL, LR, CE