

## Classification

EN ISO 3580-A	EN ISO 3580-B	AWS A5.5	AWS A5.5M
E CrMo2L B 4 2 H5	E5518-2C1ML H5	E8018-B3L	E5518-B3L

## Characteristics and typical fields of application

Fully synthetic basic covered Cr-Mo alloyed low carbon electrode, preferred for welding of creep-resistant steels alloyed with 2,25Cr-1Mo. Recommended for steam generating power plants (for welding piping, heavy-duty boilers, superheaters, superheater-lines).

The fully synthetic cover ensures easy handling, designed for welding under difficult welding conditions.

Compared to BÖHLER FOX P 22 the lower carbon version (LC) is also applicable for weld repair when post weld heat treatment is not possible. The lower carbon content provides lower hardness in the "as-welded" condition.

For higher creep strength requirements, we recommend BÖHLER FOX P 22.

Both types are not recommended for applications where temper embrittlement resistance (step cooling) is required.

## Base materials

10CrMo9-10, 12CrMo9-10, 10CrSiMoV7, 15CrMoV5-10;  
ASTM A335 Gr. P22, A217 Gr. WC9

## Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn	Cr	Mo
wt.-%	0.04	0.3	0.6	2.2	1.0

## Mechanical properties of all-weld metal

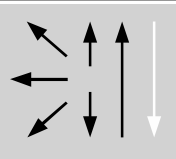
Condition	Yield strength R <sub>p0,2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	-20 °C
u	≥ 510	≥ 680	≥ 20	≥ 80	
a	≥ 460	≥ 550	≥ 22	≥ 120	≥ 47
a1	≥ 460	≥ 550	≥ 22	≥ 120	≥ 47

u as welded

a annealed, 690 °C/1 h

a1 annealed, 690 °C/10 h

## Operating data

	Polarity:	Redrying if necessary:	Electrode identification:	ø (mm)	L mm	Amps A
	DC ( + )	300 – 350°C, min. 2 h	FOX P 22 LC 8018-B3L E CrMo2L B	2.5	350	80 – 105
				3.2	350	100 – 150
				4.0	350	140 – 200
				5.0	450	170 – 250