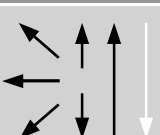


Classification						
EN ISO 3580-A	EN ISO 3580-B	AWS A5.5	AWS A5.5M			
E CrMo2 B 4 2 H5	E6218-2C1M H5	E9018-B3	E6218-B3			
Characteristics and typical fields of application						
<p>Fully synthetic basic covered CrMo alloyed electrode preferred for welding of creep-resistant steels alloyed with 2,25Cr-1Mo. Recommended for steam generating power plants (for welding piping, heavy-duty boilers, super heaters and super heater lines).</p> <p>The fully synthetic cover ensures easy handling, designed for welding under difficult welding conditions.</p> <p>For repairs of aged material, the low carbon type BÖHLER FOX P 22 LC (C < 0.05 %) is recommended.</p> <p>Both types are not recommended for applications where temper embrittlement resistance (step cooling) is required.</p>						
Base materials						
<p>10CrMo9-10, 12CrMo9-10, 10CrSiMoV7, 15CrMoV5-10; ASTM A335 Gr. P22, A217 Gr. WC9</p>						
Typical analysis of all-weld metal (wt.-%)						
	C	Si	Mn	Cr	Mo	
wt.-%	0.06	0.3	0.7	2.2	1.0	
Mechanical properties of all-weld metal						
Condition	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	-20 °C	
a	≥ 530	≥ 620	≥ 22	≥ 120	≥ 47	
a1	≥ 530	≥ 620	≥ 22	≥ 120	≥ 47	
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 9018-B3 E CrMo2 B	2.5	350	80 – 105
				3.2	350	100 – 150
				4.0	350	140 – 200
				5.0	450	170 – 250