CROMOCORD 9M

TOP FEATURES

- Approved for operating temperature up to +625°C.
- The Nickel free weld metal improves the tensile strength at high temperature.
- Very low diffusible hydrogen (HD<4ml/100g).
- Excellent radiographic examination results
- Offers excellent operability in all position welding except vertical down
- Stable arc with low spatter, easy slag removal and excellent bead profile.

CLASSIFICATION

AWS A5.5	E9018-B91 H4
EN ISO 3580-A	E Z CrMo9V B 4 2 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV
+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Cr	Mo	Nb	V	N
0.09	0.95	0.25	0.01	≤0.010	9	1	0.07	0.20	0.04

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
AWS A5.5	PWHT	≥530	≥620	≥17	not specified
EN ISO 3580-A	PWHT	≥460	≥550	≥17	not specified
Typical values	760°C x 2h	550	640	18	60

* PWHT: Postweld Heat Treatment 725-755°C / min 1h

Preheat and interpass temperature: 205-260°C

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	60-90
3.2 x 350	85-130
4.0 x 450	130-160
5.0 x 450	180-230

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5x300	CBOX	195	3.7	W100258353
3.2x350	CBOX	110	4.1	W100258354
4.0x450	CBOX	70	5.2	W100258355
5.0x450	CBOX	45	5.2	W100258356

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.