

# CARBOROD KV5

## TOP FEATURES

- Very clean welding wire with guaranteed X<15 ppm Bruscato factor, and with controlled As, Sb, Sn content against temper embrittlement.
- Also suitable where some resistance to hydrogen attack by sulphur bearing crude oil is required.

## TYPICAL APPLICATIONS

- Petrochemical
- Nuclear Power generation
- Boilers, plates, tubes
- Quenched and tempered steels

## CLASSIFICATION

AWS A5.28 ER 80S-B2  
EN ISO 21952-B W 55 I1 1CM

## SHIELDING GASES (ACC. EN ISO 14175)

I1 Inert gas Ar (100%)

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

| C    | Mn   | Si   | P      | S      | Cr   | Mo    |
|------|------|------|--------|--------|------|-------|
| 0.08 | 0.56 | 0.50 | ≤0.020 | ≤0.020 | 1.25 | ≤0.50 |

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

|                | Shielding gas | Condition*    | Yield strength (MPa) | Tensile strength (MPa) | Elongation (%) | Impact ISO-V (J) -29°C |
|----------------|---------------|---------------|----------------------|------------------------|----------------|------------------------|
| Typical values | I1            | PWHT 620°C/1h | ≥470                 | ≥550                   | ≥20            | ≥47                    |
|                | I1            | PWHT 690°C/1h | ≥355                 | ≥550                   | ≥20            | ≥70                    |

\*PWHT = Post Welding Heat Treatment

## PACKAGING AND AVAILABLE SIZES

| Diameter x Length (mm) | Packaging | Weight (kg) | Item number |
|------------------------|-----------|-------------|-------------|
| 1.6                    | PE Tube   | 5.0         | W000402711  |
| 2.0                    | PE Tube   | 5.0         | W000283649  |
| 2.4                    | PE Tube   | 5.0         | W000283650  |

## 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](http://www.lincolnelectric.eu) for any updated information.