Kryo® 3

TOP FEATURES

- Recovery about 115 - 120%
- Excellent impact toughness down to -80°C
- Good CTOD at -10°C
- Extremely low hydrogen content

CLASSIFICATION

AWS A5.5	E8018-C1-H4
EN ISO 2560-A	E 46 8 3Ni B 32 H5*

* Nearest classification

CURRENT TYPE

AC/DC(+/-)

WELDING POSITIONS

All positions, except vertical down

APPROVALS

LR	TÜV
+	+

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

C	Mn	Si	P	S	Ni	HDM
0.05	0.7	0.3	0.015	0.01	2.5	2 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -60°C	-80°C
Required: AWS A5.5	SR	min. 460	min. 550	min. 19	min. 27	-
EN ISO		min. 460	530-680	min. 20	-	min. 47
Typical values	AW	520	600	26	120	60
	SR:620°C/1h	500	590	29	90	-

AW = As welded; SR = Stress relieved

CTOD value at -10°C > 0.25 mm

SR = 605±14°C/1h

- = not specified

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	80-140
4.0 x 350	120-170

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	VPMD	53	2.0	524604-2
4.0 x 350	VPMD	37	2.0	524574-2

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.