

Kryo[®] 3

Key Features

- Basic all positional offshore stick electrode with approx. 2.5% Ni
- Excellent impact properties down to -80°C
- Extremely low hydrogen content
- Supplied in Sahara Ready Pack (SRP)

Typical Applications

- Low temperature steels such as A333 Gr6, A350 Gr LF2
- Suitable for welding weather steel grades

Conformances

AWS A5.5/A5.5M:	E8018-C1 H4
AS/NZS 4855-A:	E 46 8 3Ni B 32 H5* (*closest)
AS/NZS 4855-B:	E 5518-N5 AP U H5
LR:	5Y40H

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
3.2	350	524604-1	SRP 2.4 kg (8 x SRP per carton)
4.0	350	524574-1	SRP 1.5 kg (8 x SRP per carton)

Mechanical Properties - As required per AWS A5.5 & AS/NZS 4855-A

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -60°C
Requirements - AWS	460 min	550 min	19 min	27
Requirements - AS/NZS	460 min	530-680	20 min	47 min @ -80°C
Typical Results - As Welded	520	600	26	120
Stress Relieved @ 610C / 2hrs	500	590	29	90

CTOD @ -10C > 0.25mm

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.05	0.7	0.3	0.015	0.01
	%Ni	%Cr	%Mo	%V	Diffusible Hydrogen
Typical Results - As Welded	2.5	<0.03	<0.03	<0.03	2 ml / 100 g

Typical Operation Procedures

Polarity	Current (amps)		
	2.5mm	3.2mm	4.0mm
AC / DC±	55-80	80-140	120-170