

CROMO E225

TOP FEATURES

- Stable arc with excellent bead shape.
- Preheat min 160°C, Interpass max 250°C.
- Suitable for use with either DC positive and with AC.

CLASSIFICATION

AWS A5.5 E9015-B3 H4
EN ISO 3581-A E CrMo2 B 22 H5

CURRENT TYPE

DC+/AC

WELDING POSITIONS

All position, except vertical down

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

C	Mn	Si	P	S	Cr	Mo
0.1	0.7	0.25	≤0.010	≤0.010	2.3	1.1

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					-20°C	-40°C
AWS A5.5	PWHT	≥530	≥620	≥17	not specified	not specified
EN ISO 3580-A	PWHT	≥400	≥500	≥18	not specified	not specified
Typical values	690°C x 1h	610	720	22	120	80
	690°C x 8h	500	620	22	180	140

*PWHT: Postweld Heat Treatment 690-750°C/min. 1h

Preheat and interpass temperature: 200-300°C

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	85-130
4.0 x 450	130-170
5.0 x 450	150-220

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	CBOX	120	4.0	W100287666
4.0 x 450	CBOX	86	5.5	W100287667
5.0 x 450	CBOX	55	5.3	W100287668

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.