

Kryo® 1-180

TOP FEATURES

- Extremely low hydrogen content.
- Approx. 175% recovery, easy slag release, weldable on AC and DC.
- Filling horizontal V- and X-grooves.

CLASSIFICATION

AWS A5.5	E8018-G H4R
EN ISO 2560-A	E 50 5 1Ni B 73 H5

CURRENT TYPE

AC/DC(+/-)

WELDING POSITIONS

All position, except vertical down

APPROVALS

BV	DNV	TÜV	DB
+	+	+	+

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

C	Mn	Si	P	S	Ni	HDM
0.07	1.2	0.3	0.02	0.0010	0.9	2 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					-40°C	-50°C
Required: AWS A5.5		min. 460	min. 550	min. 19	not specified	
EN ISO		min. 500	560-720	min. 18		min. 47
Typical values	AW	550	640	26	90	60
	SR:600°C/4h	540	620	24	100	85

AW = As welded; SR = Stress relieved

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
4.0 x 450	170-240
5.0 x 450	250-300

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
4.0 x 450	VPMD	23	2.3	524734-1
5.0 x 450	VPMD	16	2.3	524772-1

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.