Kryo® 1P

TOP FEATURES

- Excellent mechanical properties (impact down to -60°C).
- Good CTOD at -10°C.
- Extremely low hydrogen content.
- 112 - 120% recovery.
- Weldable on AC and DC.

CLASSIFICATION

AWS A5.5	E8018-G-H4R
EN ISO 2560-A	E 50 6 Mn1Ni B 32 H5

CURRENT TYPE

AC/DC(+/-)

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	LR	BV	DNV	TÜV	DB
+	+	+	+	+	+

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

C	Mn	Si	P	S	Ni	HDM
0.05	1.5	0.5	0.010	0.005	0.95	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	-60°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	24	140	80
	SR:580°C/15h	460	550	24	150	90

AW = As welded; SR = Stress relieved

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	55-85
3.2 x 350	80-145
3.2 x 450	80-145
4.0 x 350	120-185
4.0 x 450	120-185
5.0 x 450	180-270

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VMPD	110	2.1	519211-2
3.2 x 350	VMPD	54	2.0	519181-2
3.2 x 450	VMPD	54	2.5	519273-2
4.0 x 350	VMPD	37	2.0	519198-2
4.0 x 450	VMPD	37	1.9	519280-3
5.0 x 450	VMPD	23	2.5	519204-2

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.