

CROMOCORD 10M

TOP FEATURES

- The weld metal chemistry is low in impurity elements (P,S).
- Excellent tensile strength at high temperature.
- Particularly suited for surfacing and joining application thick-walled steel casting.
- Very low diffusible hydrogen (HD<4ml/100g).
- Specialized coated electrode for welding cast turbine casing.
- Offers excellent operability in all position welding except vertical down

CLASSIFICATION

AWS A5.5 E9018-G H4
EN ISO 3580-A E Z CrMoWV10 B 4 2 H5

* Nearest classification

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	W	N	Al
0.11	0.8	0.25	0.010	0.008	9.5	0.5	1	0.05	0.22	1	0.05	0.01

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
AWS A5.5	AW or PWHT	≥530	≥620	≥17	not specified
EN ISO 3580-A	AW or PWHT	not specified	not specified	not specified	not specified
Typical values	730°C x 12h	620	760	≥17	≥60

* PWHT: Postweld Heat Treatment as agreed between purchaser and supplier

AW: As-welded (preheat and interpass temperature as agreed between purchaser and supplier)

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	80-130
4.0 x 450	140-180
5.0 x 450	180-230

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2x350	VPMD	51	1.9	W100258367
4.0x450	VPMD	32	2.4	W100258368
5.0x450	VPMD	18	2.1	W100258369

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.