

# CROMOCORD 9

## TOP FEATURES

- Excellent tensile strength at high temperature, approved up to +600°C.
- Low diffusible hydrogen (HD<4ml/100g).
- Stable arc with excellent bead shape and excellent operability in all position welding except vertical down

## CLASSIFICATION

AWS A5.5	E8015-B8 H4
EN ISO 3580-A	E Z (CrMo9) B 22 H5
EN ISO 3580-B	E 5515-9C1M H5

## 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
0.08	0.7	0.4	≤0.015	≤0.015	9	0.06	1

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
AWS A5.5	PWHT	≥460	≥550	≥19	not specified
EN ISO 3580-B	PWHT	≥460	≥550	≥17	not specified
Typical values	750°C x 2h	500	650	22	50

\* PWHT: Postweld Heat Treatment 725-755°C / min 1h

Preheat and interpass temperature: 205-260°C

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	65-95
3.2 x 350	90-130
4.0 x 350	135-165

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	90	1.8	W100287721
3.2 x 350	VPMD	54	2.0	W100287722
4.0 x 350	VPMD	40	2.1	W100287723

## 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.  
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