

Kryo[®] 1P

Key Features

- Designed to produce a 1% Ni deposit
- Excellent impact properties down to -60°C
- Extreme low hydrogen content
- 110-120% recovery, weldable on AC and DC
- Supplied in Sahara Ready Pack (SRP)

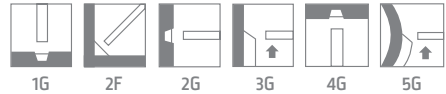
Conformances

AWS A5.5/A5.5M:	E8018-G H4R
AS/NZS 4855-A:	E 50 6 Mn1Ni B 3 2 H5
AS/NZS 4855-B:	E 5518-G A U H5
DNV:	5Y46H5

Typical Applications

- Suitable for welding prequalified procedures for steel group 8C according to AS/NZS 1554.1 Table 4.6.1.
- Basic all position offshore electrode complying with NACE 1% Ni limits
- Suitable colour match for weathering steels
- General fabrication of higher strength steels with low temperature properties

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.5	350	519211-1	SRP 1.3 kg (10 x SRP per carton)
3.2	450	519273-1	SRP 2.4 kg (8 x SRP per carton)
4.0	450	519280-1	SRP 2.0 kg (8 x SRP per carton)

Mechanical Properties - As required per AWS A5.5 & AS/NZS 4855-A

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -60°C
Requirements - AWS	460 min	550 min	19 min	-
Requirements - AS/NZS	500 min	560-720	18 min	47 min
Typical Results - As Welded	550	640	24	80
Stress Relieved @ 580°C / 15hr	460	550	24	90

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.05	1.5	0.5	0.010	0.005
	%Ni	%Cr	%Mo	%V	Diffusible Hydrogen
Typical Results - As Welded	0.95	<0.03	<0.03	<0.03	<3 ml / 100 g

Typical Operation Procedures

Polarity	Current (amps)		
	2.5mm	3.2mm	4.0mm
AC / DC±	55-85	80-145	120-170