

# CROMOCORD KV5HR

## TOP FEATURES

- Excellent tensile strength at high temperature, approved up to +570°C.
- Very low diffusible hydrogen (HD<4ml/100g).
- Excellent operability in all position welding except vertical down.

## CLASSIFICATION

AWS A5.5	E8018-B2 H4R
EN ISO 3580-A	E (CrMo1) B 32 H5
EN ISO 3580-B	E (55XX-1CM) B 32 H5

## CURRENT TYPE

DC+

## WELDING POSITIONS

All position, except vertical down

## APPROVALS

TÜV	DB
+	+

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

C	Mn	Si	P	S	Cr	Mo
0.08	0.75	0.25	≤0.01	≤0.01	1.25	0.5

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					-30°C	-40°C
AWS A5.5	PWHT	≥460	≥550	≥19	not specified	not specified
EN ISO 3580-A	PWHT	≥460	≥550	≥17	not specified	not specified
Typical values	690°C x 1h	525	610	25	100	60
	690°C x 5h	515	610	29	160	not specified
	690°C x 1h + STC	490	595	29	140	not specified

\* PWHT: Postweld Heat Treatment 675-705°C / min 1h

STC = Step cooling

Preheat and interpass temperature: 160-190°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	125-165
4.0 x 450	125-165
5.0 x 450	170-220

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	80	1.6	W100287628
3.2 x 350	VPMD	55	2.0	W100287629
4.0 x 350	VPMD	40	2.1	W100287630
4.0 x 450	VPMD	40	2.7	W100380266
5.0 x 450	VPMD	20	2.2	W100287631

## 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](http://www.lincolnelectric.eu) for any updated information.