

CROMOCORD KV5L

TOP FEATURES

- Approved up to +570°C.
- Low diffusible hydrogen (HD<5ml/100g).
- Excellent operability in all position welding except vertical down.
- Stable arc with excellent bead shape.
- Preheat min 160°C, Interpass max 250°C.
- Efficiency about 105%.

CLASSIFICATION

AWS A5.5	E7015-B2L H4
EN ISO 3580-A	E (CrMo1L) B 22 H5
EN ISO 3580-B	E (52XX-1CML) B 22 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

RINA	TÜV
+	+

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

C	Mn	Si	P	S	Cr	Mo
0.04	0.7	0.27	≤0.015	≤0.015	1.25	0.5

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -20°C
AWS A5.5	PWHT	≥390	≥520	≥19	not specified
EN ISO 3580-A	PWHT	≥390	≥520	≥17	not specified
Typical values	690°C x 1h	420	550	23	47

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

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

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	CBOH	180	3.6	W100287632
3.2 x 350	CBOX	120	4.4	W100287633
4.0 x 350	CBOX	85	4.4	W100287634

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.