Kryo® 1

Key Features

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

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 steels with low temperature properties

Conformances

AWS A5.5/A5.5M:	E7018-G H4R
AS/NZS 4855-A:	E 50 6 Mn1Ni B 3 2 H5
AS/NZS 4855-B:	E 5518-G A U H5
ABS:	3Y
LR:	5Y40H5

Welding Positions

Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.5	350	524383-1	SRP 1.3 kg (10 x SRP per carton)
3.2	350	524390-1	SRP 1.9 kg (8 x SRP per carton)
4.0	350	524468-1	SRP 1.5 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	390 min	480 min	25 min	-
Requirements - AS/NZS	500 min	560-720	18 min	47 min
Typical Results - As Welded	550	640	24	90
CTOD @ -10C > 0.25mm				

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.05	1.5	0.4	<0.01	<0.01
	%Ni	**%Cr**	**%Mo**	**%V**	**Diffusible Hydrogen**
Typical Results - As Welded	0.90	<0.03	<0.03	<0.03	2 ml / 100 g

Typical Operation Procedures

Current (amps)			
Polarity	**2.5mm**	**3.2mm**	**4.0mm**
AC / DC±	55-80	80-140	120-170