Kryo® 1R

TOP FEATURES

- Excellent mechanical properties (impact down to -60°C).
- Weldable on AC and DC.
- Extremely low hydrogen content.

CLASSIFICATION

AWS A5.5	E8018-C3-H4R
EN ISO 2560-A	E 46 6 1Ni B 32 H5

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	LR	BV	DNV	TÜV	DB
+	+	+	+	+	+

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

C	Mn	Si	P	S	Ni	HDM
0.07	1.15	0.4	0.015	0.005	0.9	2 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C	-60°C
Required: AWS A5.5		470-550	550	min. 24		47
EN ISO 2560-A		460	530-680	min. 20		
Typical values	AW	520	585	24	140	115

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	110	2.2	524809-2
3.2 x 350	VPMD	54	1.9	524816-2
4.0 x 350	VPMD	37	1.9	524823-2

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.