

# Kryo® 2

## TOP FEATURES

- Excellent impact toughness at -60°C.
- Good CTOD at -15°C.
- Extremely low hydrogen content.

## CLASSIFICATION

AWS A5.5 E9018-G-H4R  
EN ISO 2560-A E 55 6 Z B 32 H5

## CURRENT TYPE

AC/DC(+/-)

## WELDING POSITIONS

All position, except vertical down

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

C	Mn	Si	P	S	Ni	HDM
0.05	1.6	0.3	0.015	0.01	1.5	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	-50°C	-60°C
Required: AWS A5.5		min. 530	min. 620	min. 17	not specified		
EN ISO		min. 550	610-780	min. 18			min. 47
Typical values	AW	570	650	22	140	110	60
	SR:620°C/1h	530	620	22			

AW = As welded; SR = Stress relieved

CTOD value at -10°C > 0.25 mm

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	55-85
3.2 x 450	80-140
4.0 x 450	120-170

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 450	SRP	50	2.5	524659-1
4.0 x 450	SRP	28	2.0	524666-1

### 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.