CROMOBAZ

TOP FEATURES

- Excellent operability in all position welding except vertical down.
- Stable arc with excellent bead shape.
- Efficiency 120%.

CLASSIFICATION

AWS A5.5	E8018-B2 H4
EN ISO 3580-A	E CrMo1 B 42 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV	CE
+	+

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

C	Mn	Si	P	S	Cr	Mo
0.065	0.9	0.45	≤0.015	≤0.010	1.30	0.50

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
AWS A5.5	PWHT 690°C/1h	≥460	≥550	≥19	not specified
EN ISO 3580-A	PWHT 690°C/1h	≥355	≥510	≥20	≥47
Typical values	PWHT 690°C/1h	≥460	550-690	≥20	≥60

* PWHT: Postweld Heat Treatment

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	60-90
3.2 x 450	110-135
4.0 x 450	140-190
5.0 x 450	200-240

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	87	2.0	W000384498
3.2 x 450	VPMD	53	2.5	W000384499
4.0 x 450	VPMD	37	2.5	W000384500

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.