

MOLYCORD KV2HR

TOP FEATURES

- Approved up to +530°C. Very low diffusible hydrogen (HD<4ml/100g).
- Excellent bead shape, low spatter and excellent operability in all position welding except vertical down
- Preheat min 90°C, interpass max 120°C

CLASSIFICATION

AWS A5.5 E7018-A1 H4R
EN ISO 3580-A E (Mo) B 32 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV

+

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

C	Mn	Si	P	S	Mo
0.08	0.8	0.45	≤0.015	≤0.015	0.53

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					+20°C	-20°C
AWS A5.5	PWHT	≥390	≥490	≥22	not specified	not specified
EN ISO 3580-A	PWHT	≥390	≥490	≥22	not specified	not specified
Typical values	620°C x 1h	550	610	25	140	50

* PWHT: Postweld Heat Treatment 605-645°C / min 1h

Preheat and interpass temperature: 160-190°C

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
5.0 x 450	170-220

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	VPMD	80	1.6	W100287612
3.2 x 350	VPMD	55	2.1	W100287613
4.0 x 350	VPMD	40	2.1	W100287614
5.0 x 450	VPMD	20	2.2	W100287615

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.