

CROMO E225V

TOP FEATURES

- Stable arc with excellent bead shape.
- Suitable for use with DC+
- Very low diffusible hydrogen (HD<4ml/100g).

CLASSIFICATION

AWS A5.5	E9015-G H4
EN ISO 3580-B	E 6215-2C1MV H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

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

C	Mn	Si	P	S	Cr	Mo	Nb	V
0.09	0.6	0.2	≤0.010	≤0.010	2.3	1	0.020	0.25

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -30°C
AWS A5.5	AW or PWHT	≥530	≥620	≥17	not specified
EN ISO 3580-B	AW or PWHT	≥530	≥620	≥15	not specified
Typical values	710°C x 8h	590	700	18	130

PWHT: Postweld Heat Treatment 725-755°C / min 2h

AW: As-welded (preheat and interpass temperature: 180-250°C)

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	85-130
4.0 x 450	130-170
5.0 x 450	150-220

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	VPMD	58	1.9	W000402675
	CBOX	120	4.0	W100287673
4.0 x 450	CBOX	90	5.5	W100287674
5.0 x 450	CBOX	55	5.3	W100287675

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.