

Lastek 1216

Welding of creep resistant steel 13CrMo4 4

CLASSIFICATION

EN ISO 3580-A : E CrMo1 B 3 2

AWS A5.5 : E 8018-B2

GENERAL DESCRIPTION

Chromium-molybdenum alloyed low hydrogen welding electrode for welding creep resistant steels (1Cr-0.5Mo).

Field of application up to operational temperatures of 550 °C.

APPLICATIONS

Steam pipes, super heaters, petroleum cracking plants, power plants...

Welding of 13CrMo4 4, GS-17CrMo5 5.

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

C : 0.07	Mn : 0.65	Si : 0.55	Cr : 1.20	Mo : 0.50
P : < 0.02	S : < 0.02			

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 355 MPa	≥ 510 MPa	≥ 20%	≥ 47 J (-20°C)

GENERAL INFORMATION

Welding positions All, except vertical down.

Shielding gas NA

Packing 5 kg in a plastic box

Polarity DC, reverse polarity (electrode positive)

Diameter (mm) 2.5 3.2 4.0

Lenght (mm) 350 350 350

Approx. current (A) 75 - 95 100 - 130 140 - 180

Tips & tricks

Weld with a short arc, electrode almost perpendicular to the work piece.

Always use dry electrodes to obtain the highest possible mechanical characteristics. Rebaking at 300 °C for 2 hours.

Heat treatment:

Preheating 150 °C - 250 °C

Stress relieving: 720 °C

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.