HILCO B12Mo

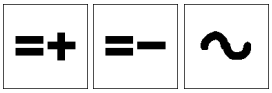
Stick electrodes – low alloyed steel – creep resisting

AWS A5.5: E 7018-A1 H4R

EN ISO 3580-A: E Mo B 32 H 5

Coating type:
Basic

Current:



Welding positions:

B12Mo is our basic-coated low hydrogen (H_{DM} < 5 ml. / 100 gr. deposit weld metal) electrode for welding low alloyed fine grain and creep resisting steels like 16Mo3 up to a maximum operating temperature of 500°C. Typical applications include the construction of pressure vessels, boilers and pipes. B12Mo is preferably welded on DC current, root pass and narrow gap welding on DC-polarity.

Base materials to be welded:

- Boiler steel P235GH-P310GH, 16Mo3, 17Mo3, 16Mo5, 14Mo6, 15NiCuMoNb5, 17MnMoV64, A355 Grade P1
- Fine grain steel S275N-S500N, P355NH-P460NH, S355NL-S500NL
  API 5L X52-X70

Applications:

- Power Generation
- Oil & Gas Industry
- Repair & Maintenance
- Process Industry

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P	Mo
0,05	0,8	0,6	0,01	0,02	0,55

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	550	610	25	-20°C ≥ 70
Stress relieved	560	620	25	-20°C ≥ 50

Note: stress relieved condition 620ºC / 1 h.

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	350	22,8	80-85
3,2	350	37,9	120-130
4,0	350	54,8	140-150