



HILCO B19CrMo

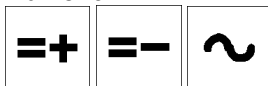
Stick electrodes – low alloyed steel – creep resisting

AWS A5.5: E 8018-B2 H4

EN ISO 3580-A: E Cr Mo 1 B 32 H5

Coating type:
Basic

Current:



Welding positions:



B19CrMo 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 13CrMo4 5 up to a maximum operating temperature of 550°C. Typical applications include the construction of pressure vessels, boilers and pipes. B19CrMo is preferably welded on DC current, root pass and narrow gap welding on DC-polarity.

Base materials to be welded:

- Boiler steel 13CrMo4-5, 15CrMo5, 16CrMoV4, A 333 Grade P 11, P 12, G-17CrMo5-5, 22Mo4, G-22CrMo 5-4, 42CrMo4
- Heat treatable steels up to 780 MPa tensile strength
- Case hardening and nitriding steels

Applications:

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

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P	Cr	Mo
0,06	0,75	0,6	0,01	0,015	1,10	0,50

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
Stress relieved	570	640	24	20°C 180 -20°C 100

Notes: stress relieved condition 700°C / 1 h. - preheat, interpass and PWHT are essential for obtaining properties as indicated. Recommended preheat 200-250°C, PWHT 660-700°C.

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	350	21,0	80-85
3,2	350	37,9	120-130
4,0	350	54,9	140-150