



HILCO B20CrMo

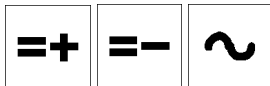
Stick electrodes – low alloyed steel – creep resisting

AWS A5.5: E 9018-B3 H4

EN ISO 3580-A: E Cr Mo 2 B 32 H5

Coating type:
Basic

Current:



Welding positions:



B20CrMo 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 10CrMo9.10 up to a maximum operating temperature of 600°C. Typical applications include the construction of pressure vessels, boilers and pipes. B20CrMo is preferably welded on DC current, root pass and narrow gap welding on DC-polarity.

Base materials to be welded:

- Boiler steel 10CrMo9.10, A335 Grade P22, 10CrSiMoV7 (1.8075), G17CrMo9.10 (1.7379)
- Heat treatable steels up to 980 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	0,8	0,6	0,010	0,015	2,3	1,0

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
Stress relieved	530	650	22	-10°C 90 20°C 150

Notes: stress relieved condition 695°C / 1 h. - preheat, interpass and PWHT are essential for obtaining properties as indicated. Recommended preheat 200-300°C, PWHT 690-750°C

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
3,2	350	37,6	120-130
4,0	350	56,7	140-150