RUTWELD CrMo

Electrodes MMA [SMAW]

Creep resistant steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 2560-A : E CrMo1 R 12 DIN 8575 : E CrMo1 R 22 AWS A-5.5 : E 8013-G	UDT	Power generation industry Constructions & Engineering

- Rutile electrode with the addition of Cr and Mo.
- For welding creep resistant steels up to 550°C.
- For remelting in situations where TIG technology cannot be used.

Application

Recommended for penetration layers and thin materials.

Welding of tanks, sheets, pipes made of steel dedicated to this type of weld metal.

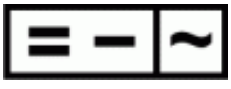
Base material

DIN	W.Nr.
13CrMo4-4, 13CrMo4-5	1.7357
15CrMo5	1.7205
42CrMo4, 42Crmo4V, 41CrMo4V	1.7225
16CrMoV4	1.7728
25CrMo4	1.7218
24CrMo5	1.7258
GS-22CrMo5-4	1.7354
GS-17CrMo5-5	1.7357
16CrMo4-4	1.7337
15CrMo3	
13CrMoV42	

Typical chemical composition %

C	Si	Mn	Cr	Mo
0,08	0,30	0,50	1,00	0,50

Typical mechanical properties

Yield strength Re [N/mm2]	>355
Tensile strength Rm [N/mm2]	>510
Elongation A5 [%]	>20
Impact energy Kv [J]	>47J (20°C) /
Coating type	rutile
Heat treatment	680°C / 2h annealing, up to 300°C airing
Welding current	

	
Welding positions	120°C / 1h

Welding parameters and packing

ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
1,6	250 /	30-50	3,0	18,0	151
2,5	350 /	70-95	4,0	16,0	48-49
3,2	350 /	115-145	4,0	16,0	
4,0	450 /	145-190	5,5	22,0	14,0
5,0	450 /	200-240	5,5	22,0	

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