

Classifications

EN ISO 18275-A	AWS A5.5 / SFA-5.5	AWS A5.5M
E 62 4 Mn1NiMo B 4 2 H5	E10018-D2 H4	E6918-D2 H4

Characteristics and typical fields of application

Basic coated MnNiMo alloyed electrode.

Very low H₂-content < 5 ml/100 g; extremely high resistance to cracking and high toughness at temperatures as low as -40°C.

For creep resistant steels and cast steel grades, valves and oil tools according to sour gas specification; postweld heat treatment: stress relieving according to parent metal.

Base materials

G30CrMoV6-4, GS-30CrMoV6-4

Steels acc. ASTM A 487-4Q; AISI 4130

Typical analysis

	C	Si	Mn	Ni	Mo
wt.-%	0.09	0.3	1.9	0.9	0.4

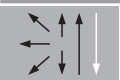
Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength	Tensile strength	Elongation A	Impact energy ISO-V KV J		
	R _{p0.2}	R _m	(L ₀ =5d ₀)	20°C	-40°C	-50°C
	MPa	MPa	%			
u	650 (≥ 620)	770 (690 - 890)	20 (≥ 18)	120	70 (≥ 47)	60
s	630	730	21	130	70	60

u untreated, as welded

s stress released at 635°C/4h

Operating data

	Polarity	DC+	Dimension mm	Current A
	Electrode identification	FOX NiMo / E 62 4 Mn1NiMo B / E10018-D2	2.5 × 350	70 – 100
	Redrying	300-350°C/2h	3.2 × 350	100 – 150
			4.0 × 450	140 – 200
			5.0 × 450	180 – 250

Choose preheating, interpass temperature and post weld heat treatment (PWHT) as required by the base material.

Approvals

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