

Revisionsnummer: 1

Classifications

EN ISO 3580-A	EN ISO 3580-B	AWS A5.5M	AWS A5.5 / SFA-5.5
E CrMo2L B 4 2 H5	E5518-2C1ML H5	E5518-B3L	E8018-B3L

Characteristics and typical fields of application

Fully synthetic basic coated Cr-Mo alloyed low carbon electrode, preferred for welding of creep-resistant steels alloyed with 2,25% Cr, 1% Mo. Recommended for steam generating power plants (for welding piping, heavy-duty boilers, superheaters, superheater-lines).

The fully synthetic cover ensures easy handling, designed for welding under difficult welding conditions.

Compared to BÖHLER FOX P 22 the lower carbon version (LC) is also applicable for weld repair when post-weld heat treatment is not possible. The lower carbon content provides lower hardness in the "as-welded" condition.

For higher creep strength requirements, we recommend BÖHLER FOX P 22.

Base materials

10CrMo9-10, 12CrMo9-10, 10CrSiMoV7, 15CrMoV5-10;
ASTM A335 Gr. P22, A217 Gr. WC9

Typical analysis

	C	Si	Mn	Cr	Mo
wt.-%	0.04	0.3	0.6	2.2	1.0

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

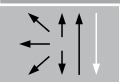
Zustand	Dehngrenze $R_{p0.2}$	Zugfestigkeit R_m	Dehnung $A (L_0=5d_0)$	Kerbschlagarbeit ISO-V KV J	
	MPa	MPa	%	20°C	-20°C
u	≥ 510	≥ 680	≥ 20	≥ 80	
a	≥ 460	≥ 550	≥ 22	≥ 120	≥ 47
a1	≥ 460	≥ 550	≥ 22	≥ 120	≥ 47

u unbehandelt, Schweißzustand

a angelassen 690 °C / 1 h

a1 angelassen 690 °C / 10 h

Operating data

	Polarity	DC (+)	Dimension mm	Current A
	Electrode identification	FOX P 22 LC 8018-B3L E CrMo2L B	2.5 × 350	80 – 105
	Redrying	300-350°C/2h	3.2 × 350	100 – 150
			4.0 × 350	140 – 200

Approvals

-