

Classifications

EN ISO 3580-A	EN ISO 3580-B	AWS A5.5M	AWS A5.5 / SFA-5.5
E CrMo2 B 4 2 H5	E6218-2C1M H5	E6218-B3	E9018-B3

Characteristics and typical fields of application

Fully synthetic basic coated CrMo alloyed 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, super heaters and super heater lines). The fully synthetic cover ensures easy handling, designed for welding under difficult welding conditions. For repairs of aged material, the low carbon type BÖHLER FOX P 22 LC (C < 0.05%) is recommended.

Base materials

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

Typical analysis

	C	Si	Mn	Cr	Mo
wt.-%	0.06	0.3	0.7	2.2	1.0

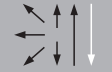
Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength R _{0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J	
	MPa	MPa	%	-20°C	20°C
a	≥ 530	≥ 620	≥ 22	≥ 47	≥ 120
a1	≥ 530	≥ 620	≥ 22	≥ 47	≥ 120

a - annealed, 690 °C/1 h

a1 - annealed, 690 °C/10 h

Operating data

	Polarity	DC +	Dimension mm	Current A
	Electrode identification	FOX P 22 9018-B3 E CrMo2 B	2.5 x 350	80 – 105
	Redrying	300-350°C/2h	3.2 x 350	100 – 150
			4.0 x 350	140 – 200

Approvals

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