

Classifications

EN ISO 3580-A:2008	: E CrMo5 B 22 H10	KS D 7022	: DT2516
EN ISO 3580-B:2008	: E 55 15-5CM H10	JIS Z 3223	: DT2516
AWS A5.5-06	: E8015-B6		

Description

- Covering is low hydrogen type for welding of 5%Cr-0.5%Mo steel used in oil refining and chemical industries, heat treated high tensile strength steel for aircraft part such as SAE 4130.
- Preheat at 250~350°C and postheat treat at 750~850°C
- Excellent crack resistance because of low hydrogen contents.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.08	0.35	0.84	0.017	0.012	0.04	5.25	0.55	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				20°C	0°C	
AWS A5.5	min. 460	min. 550	min. 19			
EN ISO 3580-A	min. 400	min. 500	min. 17	≥ 47		
Example	670	720	23	60	50	PWHT

* PWHT : 740°Cx1Hr

Sizes available and recommended currents (DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp. (A)	F V · OH	50~90 50~80	75~115 70~110	120~160 90~130	160~210	210~260

Approvals

CE