

Classification Of Creep Resisting Electrodes As Per TS EN 1599-2000

| ECrMo5 B 1 4 H5 | | | | | | | | | | | | | | | | | | | |
|-----------------|------------------------------|------|--------------|-------|-------|-----------|-----------|-----------|---------------------------------------|-------------------------|---|--|---------------|----------------------|--------------------------|-----------|----------------------------|--|-------------|
| Alloy Symbols | Chemical Composition % | | | | | | | | | | Yield Strength ReL(N/mm ²) | Tensile Strength Rm(N/mm ²) | Elong A(%) | Impact Strength J | Post Weld Heat Treatment | | Electrodes Covering | Symbol For Weld Metal Recovery And Type Of Current (%) | |
| | C | Si | Mn | P | S | Cr | Mo | V | Other | Rel(N/mm ²) | | | | | °C | Time/Min. | | | A |
| Mo | 0.10 | 0.80 | 0.40-1.50(4) | 0.03 | 0.025 | - | 0.40-0.70 | - | - | - | 355 | 510 | 22 | 47 | 570-620 | 60 | Acid Covering | 1 | 105 |
| MoV | 0.03-0.12 | 0.80 | 0.40-1.50 | 0.03 | 0.025 | 0.30-0.60 | 0.80-1.20 | 0.25-0.60 | - | - | 355 | 510 | 18 | 47 | 690-730 | 60 | Cellulosic Covering | 2 | 105 |
| CrMo0.5 | 0.05-0.12 | 0.80 | 0.40-1.50 | 0.03 | 0.025 | 0.40-0.65 | 0.40-0.65 | - | - | - | 355 | 510 | 22 | 47 | 600-650 | 60 | Rutile Covering | 3 | > 105 < 125 |
| CrMo1 | 0.05-0.12 | 0.80 | 0.40-1.50(4) | 0.03 | 0.025 | 0.90-1.40 | 0.45-0.70 | - | - | - | 355 | 510 | 20 | 47 | 660-700 | 60 | Thick Rutile Covering | 4 | > 105 ≤ 125 |
| CrMo1.1 | 0.05 | 0.80 | 0.40-1.50(4) | 0.03 | 0.025 | 0.90-1.40 | 0.45-0.70 | - | - | - | 355 | 510 | 20 | 47 | 660-700 | 60 | Rutile-Cellulosic Covering | | |
| CrMoV1 | 0.05-0.15 | 0.80 | 0.40-1.50 | 0.03 | 0.025 | 0.90-1.30 | 0.90-1.30 | 0.10-0.35 | - | - | 435 | 590 | 15 | 47 | 680-730 | 60 | Rutile-Acid Covering | | |
| CrMo2 | 0.05-0.12 | 0.80 | 0.40-1.30 | 0.03 | 0.025 | 2.0-2.6 | 0.90-1.30 | - | - | - | 400 | 500 | 18 | 47 | 690-750 | 60 | Rutile-Basic Covering | | |
| CrMo2L | 0.05 | 0.80 | 0.40-1.30 | 0.025 | 0.025 | 2.0-2.6 | 0.90-1.30 | - | - | - | 400 | 500 | 18 | 47 | 690-750 | 60 | Basic Covering | | |
| CrMo5 | 0.03-0.12 | 0.80 | 0.40-1.50 | 0.025 | 0.025 | 4.0-6.0 | 0.40-0.70 | - | - | - | 400 | 590 | 17 | 47 | 730-760 | 60 | | | |
| CrMo9 | 0.03-0.12 | 0.80 | 0.40-1.30 | 0.025 | 0.025 | 8.0-10.0 | 0.90-1.2 | 0.15 | Ni 1.0 | - | 435 | 590 | 18 | 34 | 740-780 | 60 | | | |
| CrMo9.1 | 0.06-0.12 | 0.60 | 0.40-1.50 | 0.025 | 0.025 | 8.0-10.5 | 0.80-1.20 | 0.15-0.30 | Ni 0.40-1.00 Nb 0.03-0.10 N 0.02-0.07 | - | 415 | 585 | 17 | 47 | 750-770 | 60 | | | |
| CrMoW12 | 0.15-0.22 | 0.08 | 0.40-1.30 | 0.025 | 0.025 | 10.0-12.0 | 0.80-1.20 | 0.20-0.40 | Ni 0.8 W 0.40-0.60 | - | 550 | 690 | 15 | 34 | 740-780 | 60 | | | |
| Z | Any Other Agreed Composition | | | | | | | | | | | | | | | | | | |

| Product | Symbol |
|------------------------------|--------|
| Wire Electrodes | G |
| Oxy-Acetylene | O |
| Electric Arc welding | E |
| Submerged Arc Welding Wires | S |
| Flux-Cored Wires | T |
| TIG Rods | W |
| Submerged Arc Welding Fluxes | F |

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