BASOWELD Mo

Electrodes MMA [SMAW]

Creep resistant steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 3580-A : E Mo B 42 H5 DIN 8575 : E Mo B 26 AWS A-5.5 : E 7018-A1	UDT TUV	Power generation industry Constructions & Engineering Petrochemical and chemical industry

- Basic low hydrogen electrode with Cr and Mo.
- For welding heat-resistant and creep-resistant steels, working in temperatures up to 570°C.
- Weld metal resistant to sulfur, e.g. in crude oil at temperatures of 250-450 [°C]
- Resistant to hydrogen in some applications.
- Can be used for the production of pressure vessels for NH3 up to 450[°C]
- Electrode with very good primary and secondary ignition, stable, well focused arc.
- Low spatter and good slag release, crack resistant joint, creep resistance for the life of the joint.

Base material

DIN	W.Nr.	ISO
St52-3, S355J2	1.0570	S355D
22Mo4	1.5419	
		GE240 to GE300
St45.8, P255G1TH	1.0405	
		L320 to L415NB
StE415.7TM	1.8973	L320MB-L415MB
16Mo3, 15Mo3	1.5415	16Mo3, F26
		S255NH to S500NH
		S255NL to S500NL
16Mo5	1.5423	
10MnMo4-5	1.5424	
11MnMo4-5	1.5425	
St 35.8	1.0305	
17Mn4	1.0426	P295GH, PT490
19Mn5	1.0482	PT480GH
19Mn6	1.0473	P355GH, PH29
St 50-2	1.0050	Fe490
ZStE 380, H360LA	1.0550	380Y
15NiCuMoNb5S	1.6369	
20MnMoNi4-5	1.6311	
17MnMoV6-4	1.5403	
GP240GH	1.0619	

Typical chemical composition %

C	Si	Mn	Mo
0,05	0,40	0,75	0,50

Typical mechanical properties

Yield strength Re [N/mm2]	>355
Tensile strength Rm [N/mm2]	>510 typ. >630

Elongation A5 [%]	>20
Impact energy Kv [J]	>47J (20°C) / >47J (-40°C) /
Hardness	after welding 210HB / after treatment 190HB /
Coating type	basic
Heat treatment	Heat treatment is usually carried out in the range of 630-670[°C]. In the case of materials up to 20 [mm] thick, some steel grades do not require treatment.
Hydrogen content	<5 ml/100 g
Welding current	
Welding positions	
Redrying	300 - 350°C / 2 h
Additional description	The structure of the weld metal after heat treatment is ferrite in acicular form with the addition of tempered bainite. Interstitch heating temperatures are usually in the range of 100-250[°C].

Welding parameters and packing

ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,5	350 /	70-95	4,5	13,5	48
3,2	350 /	100-130	4,5	13,5	27
4,0	350 /	140-180	4,0	12,0	15
5,0	450 /	180-230	5,5	16,5	10

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