

# TALARC CrMo B2

## CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.5: E8018-B2	EN ISO 3580-A: E CrMo1 B 4 2 H5

## ALLOY TYPE

1.25Cr-0.5Mo content to be used for the welding of creep resistant steel.

## APPLICATIONS

Low alloy basic-coated electrode with 1.25% Cr and 0.5% Mo content to be used for the welding of creep resistant steel. Suitable also for the welding of steels with 0.9% Cr and 0.5% Mo content. It is used in chemical industry and in the ammonia synthesis process, for heat exchangers, boilers, piping and pressure vessels for temperature service up to about 550°C. It will also find applications in the petro-chemical industries, suitable for facing on casting and for casting repairs.

## TYPICAL CHEMICAL COMPOSITION OF WELD METAL

C %	Mn %	Si %	S %	P %	Cu %	Ni %	Cr %	Mo %
0.065	0.70	0.40	0.015	0.010	-	-	1.30	0.50

## TYPICAL MECHANICAL PROPERTIES

	Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
	Rs	Rm	A 5d	0°C	-20°C	-30°C	-40°C	-60°C
	(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
after PWHT	520	630	24	-	90	-	-	-

## WELDING GUIDELINES

Preheat and interpass temperature 175°C. PWHT at 690°C for an hour. To be reconditioned at 300÷350°C for two hours (max 3 times) if necessary.

## TECHNICAL INFORMATION

Welding positions: all positions except vertical down



## WELDING PARAMETERS

Current	AC /DC + Reverse polarity		
	Diameter (mm)	2.5	3.2
Length (mm) *	350	350	350
Current (A)	60 ÷ 100	90 ÷ 140	130 ÷ 180

Diam.	Pack/Carton	Part No.
2.5mm	2kg VAC pack/12kg	INEB225
3.2mm	2kg VAC pack/12kg	INEB232
4.0mm	2kg VAC pack/12kg	INEB240

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