

TALARC CrMo B3

CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.5: E9018-B3	EN ISO 3580-A: E CrMo2 B 4 2 H5

ALLOY TYPE

2.25Cr-1Mo content to be used for the welding of creep resistant steel.

APPLICATIONS

Low alloy basic-coated electrode with 2.25% Cr and 1% Mo content to be used for the welding of creep resistant steel. 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 600°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	-	-	2.30	1.00

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	580	660	22	-	-	-	-	-

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	4.0
Length (mm) *	350	350	350
Intensity (A)	60 ÷ 100	90 ÷ 140	130 ÷ 180

Diam.	Pack/Carton	Part No.
2.5mm	2kg VAC pack/12kg	INEB325
3.2mm	2kg VAC pack/12kg	INEB332
4.0mm	2kg VAC pack/12kg	INEB340

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