



Premium Welding Consumables

SUPERON SCHWEISSTECHNIK INDIA LTD.

World Class Welding Electrodes  
In Technical Collaboration with M/s Kjellberg Finsterwalde gmbh, Germany.

Superior Moisture Resistant Electrode.

# SUPER CROMO 1B

**Classification:** AWS A 5.5: E 8018 – B2  
DIN 8575: E CrMo 1B20+

**DIN EN 1599:** E CrMo1B42  
**ISO 3580:** E1CrMoB

**Description / Properties:** Low hydrogen, moisture resistance basic type electrode for medium tensile, fine- grained steels. Excellent weldability in all positions.

**Application:** Electrode for joint welding at boiler and pipe steels and similar CrMo-alloyed pressure-hydrogen resistant steels, especially for the steel 13CrMo4-5 quality at working temperatures up to 550°C. Also for joint welding and surfacing on similar alloyed case hardening steels and quenched subsequently tempered steels.

**Materials:** Boiler steels: EN 10028-2: 13 CrMo 4-5  
Cast steel EN 10213-2: G 17 CrMo 5-5

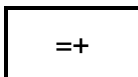
Weld metal chemical composition: (typical)%

C	Si	Mo	Mn	Cr	P	S
0.08	0.40	0.50	0.80	1.20	0.025	0.018

All weld metal mechanical properties (typical)

Yield strength N/mm <sup>2</sup>	Tensile strength N/mm <sup>2</sup>	Elongation A <sub>5</sub> %	Charpy impact value ISO-V J +20°C
>460	550-650	>20	>47

Welding recommendations:



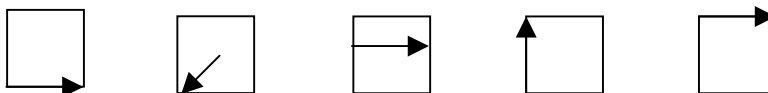
Re-drying: 300-350°C/2h

Pre- heating and interpass temperature from 250 upto 350°C depending on base material, shape of material and thickness.

**Tempering:** Min 0.5h at 700°C-down-cooling at resting air.

**Annealing:** 0.5h at 930 to 950°C- down cooling by air, afterwards at 700°C- down cooling by air.

Welding positions:



Welding current:

2.50	3.15	4.0	5.0
60- 90	100- 140	140- 180	180- 230