



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 2B

Classification: AWS A 5.5: E 9018 – B3
DIN EN 1599: ECrMo 2B42

DIN 8575: ECrMo2B20+
ISO 3580: E2 CrMoB

Description / Properties: Low hydrogen, moisture resistant basic type electrode for high tensile 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 10CrMo9-10 at working temperatures up to 600°C(permanent). Also for joint welding and surfacing on similar alloyed case hardening steels and quenched subsequently tempered steels.

Materials: Boiler steels: EN 10028-2: 10CrMo 9-10, 11CrMo 9-10
Cast steel EN 10213-2: G 17 CrMo 9-10

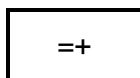
Weld metal chemical composition: (typical)%

C	Si	Mo	Mn	Cr	P	S
0.08	0.45	1.10	0.90	2.20	0.025	0.018

All weld metal mechanical properties (typical)

Yield strength N/mm ²	Tensile strength N/mm ²	Elongation A ₅ %	Charpy impact value ISO-V J +20°C
>550	620-750	>20	>47

Welding recommendations:



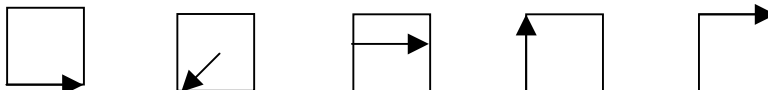
Re-drying: 300-350°C/2h

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