LEADER IN INDUSTRIAL TOOLS & EQUIPMENT

Technical sheet



BOHLER Basic stick electrode, low-alloyed, FOX DCMS KB-2,50X0350

Marque: BÖHLER- GERMANY

Ref Product: wire:68441

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Description	
68441	
BOHLER Basic stick electrode, low-alloyed, FOX DCMS KB-2,50X0350	
BOHLER Basic stick electrode, low-alloyed, creep resistant FOX DCMS KB-2,50X0350	
Basic low hydrogen electrode for 1 % Cr 0.5 % Mo alloyed boiler, plate, and tube steels. - Approved in long-term condition up to +570 °C service temperature. - Fully alloyed core wire which will provide reliable creep rupture properties for the whole service life of a boiler plant. High ductility and crack resistance. - The weld metal deposit is heat treatable. - Very low hydrogen content (acc. AWS condition HD < 4 ml/100 g). - Metal recovery approx. 115 %. Suitable for step-cooling application. Bruscato ? 15ppm. - Post weld tempering at 660 - 700 °C for at least ½ h followed by cooling in furnace down to 300 °C and still air.	
CLASSIFICATION	
EN ISO 3580-A:	E CrMo1 B 4 2 H5
EN ISO 3580-B:	E5518-1CM H5
AWS A5.5:	E8018-B2H4R
AWS A5.5M:	E5518-B2H4R
Product specification:	
Dimension:	2,50x350mm
Amps A:	80 - 110
CERTIFICATION	
TÜV (0728.), DB (10.014.32), ABS (E 8018-B2), DNV (NV 1Cr 0,5Mo), GL (13 CrMo 44), LTSS, SEPROZ, CE, NAKS (Ø 3.2 mm; Ø 4.0 mm)	