

PRODUCT DATA SHEET

Afrox KV3



Afrox KV3 is a basic coated DC type hydrogen controlled all position electrode depositing weld metal containing 2,25% chromium and 1% molybdenum. The deposits from these electrodes are characterised by excellent radiographic and metallurgical qualities which, together with exceptional weldability, make these electrodes ideally suited for positional welding. Aprox KV3 is recommended for welding a wide variety of 2,25 Cr, 1 Mo creep resisting steels.

Classifications

AWS	A5.5	E9018-B3
EN	3580-A	E Cr Mo2 B H5
EN	3580-B	E6215-2CIM H5

Typical Chemical Analysis

% Carbon	0,05 - 0,1	% Phosphorous	0,025 max
% Manganese	0,5 - 0,9	% Chromium	2,0 - 2,5
% Silicon	0,45 max	% Molybdenum	0,9 - 1,2
% Sulphur	0,025 max		

Typical Mechanical Properties

(All weld metal in the stress relieved condition to AWS A5.5)

Stress Relieving Temp.	690°C for 1 hr
0,2% Proof Stress	530 MPa min
Tensile Strength	630 - 720 MPa
% Elongation on 50 mm	20 min
Charpy V-Notch at +20°C	120 J min

Packing Data (DC+ only)

Diameter (mm)	Current (A)	Electrode Length (mm)	Pack Mass (kg)	Item Number
2,5	60 - 95	300	3 x 3,0	W075522
3,15	85 - 130	350	3 x 4,0	W075523
4,0	120 - 180	350	3 x 4,0	W075524
5,0	185 - 250	450	3 x 6,0	W075525

The information contained or otherwise referenced herein is presented only as typical without guarantee or warranty, and Aprox expressly disclaims any liability incurred from any reliance therein. No data is to be construed as recommended for any welding condition or technique not controlled by Aprox.

For more information contact the Aprox Customer Service Centre Tel: 0860 02 02 02
E-mail: customer.service@afrox.linde.com Website: www.afrox.com

