

AFROX KV5 AND KV5L



AFROX KV5 and KV5L are basic coated DC type, hydrogen controlled all position electrodes depositing weld metal containing 1,25% chromium and 0,5% molybdenum.

The deposits from these electrodes are characterised by excellent radiographic and metallurgical qualities which, together with exceptional weldability, make these ideally suited for positional welding.

The product was developed to weld a wide variety of 1,25 Cr, 0.5 Mo creep-resisting steels.

CLASSIFICATIONS

Afrox KV5

AWS	A5.5	E8018-B2
BS EN	1599	E CrMo I B

Afrox KV5L

AWS	A5.5	E7015-B2L
BS EN	1599	E CrMo I LB

CHEMICAL ANALYSIS

	Afrox KV5	Afrox KV5L			
% Carbon	0.05 - 0.10	0.05 max	% Phosphorous	0.025 max	0.025 max
% Manganese	0.50 - 0.90	0.50 - 0.90	% Chromium	1.0 - 1.3	1.0 - 1.3
% Silicon	0.45 max	0.45 max	% Molybdenum	0.04 - 0.60	0.04 - 0.60
% Sulphur	0.025 max	0.025 max			

**TYPICAL MECHANICAL PROPERTIES
(ALL WELD METAL IN THE STRESS
RELIEVED CONDITION TO AWS A5,5)**

	Afrox KV5	Afrox KV5L
Stress Relieving Temp.	690°C	690°C
0,2% Proof Stress	460 MPa min	390 MPa min
Tensile Strength	550 - 650 MPa	520 MPa min
% Elongation on 50mm	22 min	19 min
Charpy V-Notch at +20°C	90J min	
Charpy V-Notch at 0°C	70J min	
Vickers Hardness	190 - 200 HV	

PACKING DATA

(DC+ only)

Diameter (mm)	Electrode Length (mm)	Current Amps	Item Number KV5	Item Number KV5L	Pack Mass (Kg)
2.5	300	65 - 95	075-542	075-572	3 x 3
3.15	350	80-130	075-543	075-573	3 x 4
4	350	120-180	075-544	075-574	3 x 4
5	450	185-250	075-545	075-575	3 x 6

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

For more information contact the Afrox Customer Service Centre,
tel: 0860 020202 or e-mail: customer.service@afrox.boc.com
Website: www.afrox.com

