

# PRODUCT DATA SHEET

## Afrox KV5 Afrox 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
EN	3580-A	E Cr MoI B H5
EN	3580-B	E5515-ICM H5

### Classifications Afrox KV5L

AWS	A5.5	E7015-B2L
EN	3580-A	E Cr MoI L B H5
EN	3580-B	E5215-ICML H5

### Typical Chemical Analysis

	Afrox KV5	Afrox KV5L		Afrox KV5	Afrox KV5L
% Carbon	0,05 - 0,1	0,05 max	% Phosphorous	0,025 max	0,025 max
% Manganese	0,5 - 0,9	0,5 - 0,9	% Chromium	1,0 - 1,3	1,0 - 1,3
% Silicon	0,45 max	0,45 max	% Molybdenum	0,04 - 0,6	0,04 - 0,6
% 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 for 1 hr	690°C for 1 hr
0,2% Proof Stress	460 MPa min	390 MPa min
Tensile Strength	550 - 650 MPa	520 MPa min
% Elongation on 50 mm	22 min	19 min
Charpy V-Notch at +20°C	90 J min	-
Charpy V-Notch at 0°C	70 J min	-
Vickers Hardness	190 - 200 HV	-

### Packing Data (DC+ only)

Diameter (mm)	Current (A)	Electrode Length (mm)	Pack Mass (kg)	Item Number Afrox KV5	Item Number Afrox KV5L
2,5	65 - 95	300	3 x 3,0	W075542	W075572
3,15	80 - 130	350	3 x 4,0	W075543	W075573
4,0	120 - 180	350	3 x 4,0	W075544	W075574
5,0	185 - 250	450	3 x 6,0	W075545	W075575

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