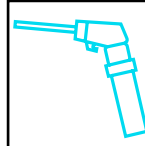


# WELDING CONSUMABLES HYDROGEN CONTROLLED ELECTRODES



### ALLOYCRAFT 80-B2 – Hermetically Sealed

70  
OCV

DC  
AC



**TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:**

0.2% Proof Stress	570 MPa.
Tensile Strength	670 MPa.
Elongation	24%.

**TYPICAL ALL WELD METAL ANALYSIS:**

C: 0.08%	Mn: 0.82%	Si: 0.39%
Mo: 0.65%	Cr: 1.40%	S: 0.013%
P: 0.015%		

**TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:**  
3.0 - 3.5 mls of hydrogen / 100gms of deposited weld metal.

**COMPARABLE CIGWELD PRODUCTS:**  
Verti-cor 80Ni 1 FCAW  
Autocraft CrMo1 GMAW

**RELEASED  
2ND QUARTER  
2004**

- ▲ Hermetically Sealed Cans.
- ▲ Improved High Strength, Low Alloy Steel Electrode.
- ▲ Advanced Flux Coating.
- ▲ Very Low "H5/H4" Diffusible Hydrogen Class.
- ▲ 550 MPa Tensile Class
- ▲ BATCH NUMBERED for On-the-Job Traceability.
- ▲ Recommended for the all positional (except vertical down) welding of Chromium and Chromium – Molybdenum bearing steels as used in elevated temperature applications.

**Classifications:**

AS/NZS 1553.2: E5518-B2.  
AWS/ASME-SFA A5.5: E8018-B2 H4.

**Packaging and Operating Data:**

AC (minimum 70 O.C.V.), DCEP (DC+) or DCEN (DC-) polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Can	Carton	Part No
2.5	350	40	65 – 100	3kg	9kg – 3 x 3kg	611922
3.2	380	22	105 – 150	3kg	9kg – 3 x 3kg	611923
4.0	380	15	145 – 200	3kg	9kg – 3 x 3kg	611924

### ALLOYCRAFT 80-C1 – Hermetically Sealed

70  
OCV

DC  
AC



**TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:**

0.2% Proof Stress	550 MPa.
Tensile Strength	630 MPa.
Elongation	26%.
CVN Impact Values	75 J av @ -60°C

**TYPICAL ALL WELD METAL ANALYSIS:**

C: 0.05%	Mn: 1.1%	Si: 0.38%
Ni: 2.46%	Cr: 2.20%	S: 0.013%
P: 0.015%		

**TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:**  
3.0 - 3.5 mls of hydrogen / 100gms of deposited weld metal.

**RELEASED  
2ND QUARTER  
2004**

- ▲ Hermetically Sealed Cans.
- ▲ Improved High Strength, Low Alloy Steel Electrode.
- ▲ Very Low "H5/H4" Diffusible Hydrogen Class.
- ▲ 550 MPa Tensile Class, Reliable Impact Toughness to -60°C.
- ▲ BATCH NUMBERED for On-the-Job Traceability.
- ▲ Suitable for the full or under matching strength welding of high strength nickel bearing steels as used for low temperature applications.

**Classifications:**

AS/NZS 1553.2: E5518-C1.  
AWS/ASME-SFA A5.5: E8018-C1 H4.

**Packaging and Operating Data:**

AC (minimum 70 O.C.V.), DC+ or DC- polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Can	Carton	Part No
3.2	380	18	110 – 145	3kg	9kg – 3 x 3kg	611833
4.0	380	12	140 – 200	3kg	9kg – 3 x 3kg	611834
5.0	450	10	190 – 270	3kg	9kg – 3 x 3kg	611835

# - Alloycraft 80-C1 is formulated to operate with AC (min 70 O.C.V.), DC+ or DC- polarity. The preferred polarity for DC welding is DC+.

### ALLOYCRAFT 90-B3 – Hermetically Sealed

70  
OCV

DC  
AC



**TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:**

0.2% Proof Stress	630 MPa.
Tensile Strength	720 MPa.
Elongation	20%.

**TYPICAL ALL WELD METAL ANALYSIS:**

C: 0.08%	Mn: 0.85%	Si: 0.35%
Mo: 1.05%	Cr: 2.20%	S: 0.013%
P: 0.015%		

**TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:**  
3.0 - 3.5 mls of hydrogen / 100gms of deposited weld metal.

**RELEASED  
2ND QUARTER  
2004**

- ▲ Hermetically Sealed Cans.
- ▲ Improved High Strength, Low Alloy Steel Electrode.
- ▲ Very Low "H5/H4" Diffusible Hydrogen Class.
- ▲ 620 MPa Tensile Class.
- ▲ BATCH NUMBERED for On-the-Job Traceability.
- ▲ Recommended for the all positional (except-down) welding of Cr-Mo and Cr-Mo-V bearing steels as used for high temperature applications.

**Classifications:**

AS/NZS 1553.2: E6218-B3  
AWS/ASME-SFA A5.5: E9018-B3 H4.

**Packaging and Operating Data:**

AC (minimum 70 O.C.V.), DCEP (DC+) or DCEN (DC-) polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Can	Carton	Part No
3.2	380	22	105 – 150	3kg	9kg – 3 x 3kg	611963
4.0	380	15	145 – 200	3kg	9kg – 3 x 3kg	611964