

# CARBO NiMoCr 90

International standards	EN 757	E 69 4 Mn2NiCrMo B T 42 H5
	DIN 8529	EY 69 75 Mn2NiCrMo B
	AWS A 5.5	E 11018-M

**Approvals** ---

**Typical applications and characteristics** CARBO NiMoCr 90 is a basic coated electrode for welding high-strength tempered low-alloy steels as well as process welding on steel castings cast steels of corresponding strength. Due to its low hydrogen content (< 5ml / 100g), the weld metal is extremely crack-proof. Store in a dry place and rebake before use. Weld stringer beads, as thin as possible, with a short arc. Preheating and intermediate layer temperature acc. to the instructions of the base metal manufacturer.

**Operating temperature** - 60 up to + 450 °C

**Base materials** StE 500 up to StE 690 V as well as N-A-XTRA 55 up to 70. S500N up to S690Q

Mechanical properties of all-weld metal (typical values)	Tensile strength $R_m$ N/mm <sup>2</sup>	Yield strength $R_{p0,2}$ N/mm <sup>2</sup>	Elongation $A_5$ %	Impact energy ISO - V J	
				- 40°C	60°C
	830	> 730	> 18	> 47	> 28

Weld metal analysis (typical, wt %)	C	Si	Mn	Ni	Cr	Mo
	0.05	0.3	1.7	2	0.4	0.4

**Current** = +

**Welding positions** PA, PB, PC, PD, PE, PF

**Rebaking** 1 h, 350 °C + / - 10 °C

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2.5 x 350	60 - 100	234	935	21.4	5.0	20.0
3.2 x 350	90 - 140	138	552	36.2	5.0	20.0
4.0 x 350	110 - 190	91	364	54.9	5.0	20.0
5.0 x 450	180 - 240	54	218	110.2	6.0	24.0