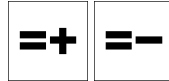


Coating type:

Basic

Arc Voltage: 70V

Current:



Tip colour:

-

Welding positions:



Printing:

Hilco B 12 Mo

B 12Mo is our basic-coated low hydrogen ($H_{DM} < 5$ ml. / 100 gr. deposit weld metal) electrode for welding low alloyed fine grain and creep resisting steels like 16Mo3 up to a maximum operating temperature of 500°C. Typical applications include the construction of pressure vessels, boilers and pipes. B 12Mo is preferably welded on DC current, root pass and narrow gap welding on DC- polarity.

Base materials to be welded:

- Boiler steel P235GH-P310GH, 16Mo3, 17Mo3, 16Mo5, 14Mo6, 15NiCuMoNb5, 17MnMoV64, A355 Grade P1
- Fine grain steel S275N-S500N, P355NH-P460NH, S355NL-S500NL
API 5L X52-X70

Applications:

- Power Generation
- Oil & Gas Industry
- Repair & Maintenance
- Process Industry

Equivalent product in alternative welding process:

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
-	SG Mo	-	Fer SG Mo	-	-

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	Al
0,06	0,80	0,40	≤ 0,010	≤ 0,020			0,50				

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 480	≥ 560	≥ 22	-40°C ≥ 40
Stress relieved	≥ 460	≥ 560	≥ 22	-40°C ≥ 60

Note: stress relieved condition 620°C / 2 h.

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	350	22,7	80-110
3,2	350	37,5	100-140
4,0	350	55,3	130-180