

PRODUCT DATA SHEET

Afrox KV2



Afrox KV2 is a basic coated hydrogen controlled electrode for all position welding of high tensile low alloy steels and creep resisting steels containing 0,5 molybdenum for service up to 450°C. The ease of operation and stability of the arc make this electrode eminently suitable for use in difficult to weld positions. The electrode deposits weld metal of high metallurgical and radiographic qualities in all positions.

Classifications

AWS	A5.5	E7018-A1
EN	3580-A	E Mo B H 5
EN	3580-B	E4915-IM3 H5

Typical Chemical Analysis

% Carbon	0,05 - 0,09	% Sulphur	0,025 max
% Manganese	0,75 - 0,9	% Phosphorous	0,025 max
% Silicon	0,45 max	% Molybdenum	0,4 - 0,6

Typical Mechanical Properties (All weld metal in the as welded condition)

0,2% Proof Stress	390 MPa min
Tensile Strength	480 MPa min
% Elongation on 50 mm	25 min
Charpy V-Notch at +20°C	120 J min

Packing Data (DC+ only)

Diameter (mm)	Current (A)	Electrode Length (mm)	Pack Mass (kg)	Item Number
2,5	65 - 95	300	3 x 4,0	W075512
3,15	85 - 130	350	3 x 4,0	W075513
4,0	120 - 180	350	3 x 4,0	W075514

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