ESAB KV4

ESAB KV4 is a 5Cr-0.5Mo alloyed basic coated low hydrogen electrode, used for welding creep resistant Cr-Mo bearing steels. It deposits a weld metal that is highly resistant to heat and corrosion. The electrode is designed to provide a stable arc, minimum spatter and superior weld bead. ESAB KV4 finds extensive use in the oil refineries, chemical and petrochemical Industries where it has to resist corrosion and hydrogen attack at high temperatures.

Specifications	
Classifications	SFA/AWS A5.5 : E8018-B6 IS 1395 : E55BB620

Welding Current	DC+
Diffusible Hydrogen	< 5 ml/100g
Alloy Type	Cr-Mo alloyed
Coating Type	Basic

Typical Tensile Properties				
Condition	**Conditional Statement**	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS				
Stress Relieved	PWHT 740°C 1h	480 MPa	570 MPa	20 %

Typical Weld Metal Analysis %				
C	**Mn**	**Si**	**Cr**	**Mo**
0.06	0.70	0.45	5.00	0.50

Deposition Data	
Diameter	**Current**
2.5 x 350.0 mm	60-90 A
3.15 x 350.0 mm	90-130 A
4.0 x 350.0 mm	120-160 A
5.0 x 450.0 mm	160-240 A