ESAB KV7

ESAB KV7 is basic coated low hydrogen electrode, for welding creep resistant steels of 9Cr-1Mo type. The weld metal is highly resistant to corrosion and hydrogen attack at high temperatures. The electrode runs with a quiet, stable arc and gives a minimum amount of spatter and superior weld appearance. It finds extensive use in the power plants, oil refineries, chemical and petrochemical industries.

Specifications	
Classifications	SFA/AWS A5.5 : E8018-B8 IS 1395 : E55BB820

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	570 MPa	680 MPa	21 %

Typical Weld Metal Analysis %				
C	**Mn**	**Si**	**Cr**	**Mo**
0.06	0.90	0.35	10.20	1.10

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	130-170 A
5.0 x 450.0 mm	160-250 A