# ESAB KV4

## A basic coated low hydrogen electrode for welding 5 Cr-0.5 Mo steels

Print

Classification AWS A5.5: E 8018-B6
IS 1395: E 55 BB 620

**DESCRIPTION**

ESAB KV4 is a basic coated all position electrode used for welding of creep resistant, Cr-Mo bearing steel. Deposited metal is highly resistant to heat and corrosion. This electrode is highly suited for welding steel having 4 to 6% Chromium and 0.5% Molybdenum. The design of the slag system, good arc characteristics, stable arc in all positions, minimum spatter level and smooth weld bead appeal to the welder. Weld deposit is of radiographic quality.

**WELDING CURRENT:** DC+

**TYPICAL APPLICATIONS**

ESAB KV4 finds extensive use in the chemical and petrochemical industries, oil industries where it has to resist corrosion and hydrogen attack at high temperatures. It is also used for welding parts of aircraft made out of SAE 4130 steels, heat treatable steels etc. Also suitable for welding 5% chromium steel castings for use at elevated temperatures.

**TYPICAL ALL WELDMETAL PROPERTIES**

| Chemical Composition (%) | | | | Mechanical Properties | |
|---|---|---|---|---|---|
| C | 0.06 | Cr | 5.60 | YS | 490 N/mm$^2$ |
| Mn | 0.80 | Mo | 0.60 | UTS | 575 N/mm$^2$ |
| Si | 0.30 | S | 0.018 | EL (L=4d) | 24% |
| P | 0.018 | | | | |

**CURRENT RANGE & PACKING DATA**

| Size (mm) | Length (mm) | Current Range (Amps) | No. of Electrodes in a | |
|---|---|---|---|---|
| | | | Carton | Cardboard box |
| 2.50 | 350 | 65-95 | 135 | 540 |
| 3.15 | 350 | 75-130 | 95 | 380 |
| 4.00 | 350 | 115-165 | 60 | 240 |
| 5.00 | 450 | 180-240 | 45 | 180 |

PACKING: Electrodes are packed in cartons and four of these cartons are shrink wrapped in a cardboard box.