

### CLASSIFICATION

EN ISO 3580 : (E CrMo 1 R 12)  
AWS A5.5 : (E8013-B2)

### GENERAL DESCRIPTION

L-8013-B2 is a rutile coated electrode. It gives a Cr-Mo alloyed weld metal that is used in the welding of creep resistant pressure vessels and pipe steels operating under high temperatures. L-8013-B2 is especially used for 13 CrMo 44 type steels that are frequently used in operating temperatures up to 570°C. It gives a root pass free of porosity with a minimum amount of spatter.

### APPROVALS

GOST, SEPRO, TSE

### CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Si	Mn	Cr	Mo
0.06	0.30	0.80	1.20	0.40

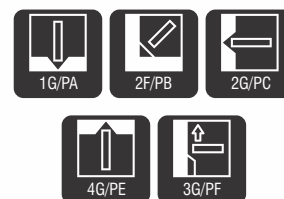
### MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 520 N/mm <sup>2</sup>
Tensile Strength	: 600 N/mm <sup>2</sup>
Elongation (L=5d)	: 22 %
Impact (ISO-V)	: 60 J (+20°C)

### WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : AC min 50 V ; DC (-)

Diameter [ mm ]	Length [ mm ]	Current [ A ]	Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export Box Box Weight [ kg ]
2.50	350	70 - 95	2200	3.3 / 150	5
3.25	350	100 - 140	3050	4.1 / 135	5



### APPLICATIONS AND MATERIALS TO BE WELDED

L-8013-B2 is used for the welding of vapor pipes and boiler and pressure vessels that are manufactured from Cr-Mo steels. L-8018-B2, a basic coated electrode, should be preferred in the multi-pass welding of thick sectioned and rigidly restrained mass structures.

	DIN	EN	Werkstoff Nr.
<b>Heat Resistant Steels</b>	15 CrMo 5	-	1.7205
	-	25CrMo4	1.7218
	-	42CrMo4 *	1.7225
	24 CrMo 5	-	1.7258
	13 CrMo 4 4	13CrMo4-5	1.7335
	22 CrMo 4 4	-	1.7350
	16 CrMoV 4	-	1.7728
<b>Cast Steels</b>	GS-25 CrMo 4	G25CrMo4	1.7218
	GS-22 CrMo 5 4	G22CrMo5-4	1.7354
	GS-17 CrMo 5 5	G17CrMo5-5	1.7357

(\* ) Mechanical proper ties should be considered.

**Liability** : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.  
**Fumes** : Consult information on Welding Safety Sheet, available upon request.