

OE-CRYO 87

MMA Electrodes C-Mn and low-alloy steels

OE CRYO 87 deposits weld metal containing 3,5% Ni and is suitable for welding fine grain steels. Used for welding steels operating at temperatures down to -101°C. Suitable for welding pipes, tanks, containers. Efficiency 100%.

Classification	
AWS	A5.5: E 7016-C2L
EN	499: E 42 6 3 Ni B 12 H5
EN ISO	2560-A: E 42 6 3Ni B 12 H5

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.04	0.50	0.40	≤ 0.020	≤ 0.015	-	3.50	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -101°C	Hardness
PWHT 620°C x 1h	≥ 440	510-640	≥ 25	≥ 60	-
As Welded	≥ 420	500-640	≥ 25	≥ 47	-

Materials

ASTM A203 gr. B; A333/ A334 gr. 3; 12Ni14

Storage and redrying

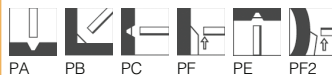
Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 400-420 °C for 1 hour, 5 times max

HD ≤ 10: Re-dry at 350-370 °C for 1 hour, 5 times max

Current condition and welding position

DC+; AC



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	60-90	17,8	10,8
3,2	350	90-140	34,9	18,6
4,0	350	120-180	53,5	27,7
5,0	450	190-250	94,9	53,4