

MMA Electrodes C-Mn and low-alloy steels

OE CRYO 75H is a low hydrogen Ni alloyed electrode, depositing high toughness weld metal. Used for the construction of tanks, etc. Use a short arc and low travel speed. Efficiency 120%.

Classification	
AWS	A5.5: E 7018-C1L
EN	499: E 42 6 2Ni B 32 H5
EN ISO	2560-A: E 42 6 2Ni B 32 H5

Approvals	Grades
DNV	
RINA	

see Appendix, Classification Society Approvals, for details pag. 521

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.03	0.50	0.30	≤ 0.015	≤ 0.015	-	2.30	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -60°C	Hardness
PWHT 620°C x 1h	≥ 420	500 - 630	≥ 26	≥ 110	-
As Welded	≥ 420	500 - 640	≥ 26	≥ 80	-

Materials

12Ni14, S275-S420, P275-P460

Storage and redrying

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 400-420 °C for 1 hour, 3 times max.

HD ≤ 10: Re-dry at 350-370 °C for 1 hour, 3 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	60-120	16,8	10,0
3,2	450	100-140	47,0	29,5
4,0	450	120-190	67,4	44,4
5,0	450	180-250	103,1	66,7