

MMA Electrodes Chromium-Molybdenum steels

Low hydrogen iron-powder electrode for the all-positional welding of steels containing 0.5% Mo and high tensile steels. Excellent weldability and arc stability. Good X-ray quality and high resistance to solidification cracking. Pre-heat and interpass temperatures between 100-150°C are recommended. Efficiency 120%.

Classification	
AWS	A5.5: E 7018-A1 H4R
EN	1599: E Mo B 32 H5
GOST	9467-75:Э09М

Approvals	Grades
TÜV	

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
0.08	0.78	0.38	≤ 0.015	≤ 0.015	-	-	0.53	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -40°C	Hardness
PWHT 620°C x 1h	≥ 390	510-600	≥ 25	≥ 60	-

Materials

16Mo3; S(P)235-S(P)420

ASTM A355 Gr. P1; A182M Gr. F1

Storage and redrying

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 400-420 °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	65-95	19,3	11,5
3,2	350	90-130	36,2	20,8
4,0	350	125-165	51,4	29,7
5,0	450	170-220	106,8	70,6