

MMA Electrodes Chromium-Molybdenum steels

Basic coated electrode for welding of creep resistant steels with 0,5 % Cr - 0,5 % Mo.

Classification

AWS	A5.5: E 8018 B1
EN	1599: E CrMo0,5 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
0.05	0.70	0.40	≤ 0.025	≤ 0.020	0.50	-	0.50	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 20 °C	Hardness
PWHT 700 °C x 1 h	≥ 355	≥ 510	≥ 20	≥ 80	-

Materials

A387 gr. 2

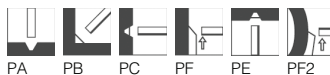
Storage and redrying

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 340-360 °C for 2 hours, 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	350	65-85	20,4	12,2
3,2	350	100-130	34,9	20,9
4,0	450	140-180	63,4	38,0
5,0	450	190-230	94,2	56,5