

MMA Electrodes Chromium-Molybdenum steels

All-positional electrode (max. 0.05%C) with a basic coating for the welding of creep resistant steels alloyed with 1.25% Cr 0.5% Mo. Also recommended for welding 0.9 Cr 0.5 Mo steel. The chemical composition of the weld metal results in a high resistance to solidification cracking. Efficiency 100%.

Classification	
AWS	A5.5: E 7015-B2L
EN	1599: E CrMo1L B 22 H5

Approvals	Grades
RINA	
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
0.04	0.77	0.44	≤ 0.015	≤ 0.015	1.25	-	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) -40°C	Hardness
PWHT 690°C x 1h	≥ 390	520 - 650	≥ 20	≥ 47	-

Materials

13CrMo4-5, 13CrMoSi5-5; G17CrMo5-5

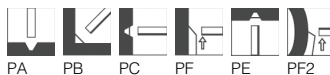
Storage and redrying

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+



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	65-95	19,1	11,4
3,2	350	90-130	35,2	21,0
4,0	350	125-165	50,0	30,0
5,0	450	170-220	97,3	58,3
6,0	450	240-290	133,0	106,4