

MMA Electrodes Chromium-Molybdenum steels

All-positional electrode with a basic coating alloyed with 1.25% Cr 0.5% Mo for the welding of creep resistant steels. OE-KV5HR is 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. Preheat and interpass temperature 150÷200°C are recommended. 120% recovery, X Factor <15ppm and J Factor <150ppm.

Classification	
AWS	A5.5: E 8018-B2 H4R
EN	1599: E CrMo1 B 32 H5
GOST	9467-75:Э09Х1М similar

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	0.80	0.35	≤ 0.010	≤ 0.010	1.28	-	0.45	-	-	-	-

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	≥ 460	550 - 690	≥ 20	≥ 47	-

A335 Gr P11; 13CrMo4-5; 13CrMoSi5-5

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+; AC



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	65 - 95	19,7	12,1
3,3	350	90 - 130	36,1	21,3
4,0	350	125 - 165	52,7	30,6
5,0	450	170 - 220	107,0	58,0