

## MMA Electrodes Chromium-Molybdenum steels

New generation Cr and 1,5%W alloyed basic coated MMA electrode, suitable for the welding of T23 and P23 steels. Excellent weldability in all positions except vertical down. Mainly used in power generation applications. X Factor < 15ppm and J Factor < 120ppm. Efficiency 100%.

### Classification

AWS A5.5: E8015-G

### Approvals

### Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.04	0.50	0.30	≤ 0.015	≤ 0.015	2	0.50	-	-	0.25	-	0.10

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) -20°C	Hardness
PWHT 740°C x 2h	≥ 460	550-640	≥ 20	≥ 27	-

### Materials

A335 P23 - A213 T23

### Storage and redrying

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 400-420 °C for 1 hour, once only.

### 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	50-80	17,7	10,3
3,2	350	65-100	33,0	21,8