

MMA Electrodes Chromium-Molybdenum steels

Low-hydrogen MMA electrode suitable for the welding of 2.25% Cr, 1.0% Mo, V steels after step cooling applications.
X Factor < 15ppm and J Factor < 120ppm.
Efficiency 100%.

Classification	
AWS	A5.5: E 9015-G
EN	1599: E Z B 22 H5

Approvals	Grades
ABS	E9015-G

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
0.09	0.60	0.20	≤ 0.010	≤ 0.010	2.30	-	1	0.012	0.25	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -18°C	Hardness
PWHT 710°C x 8h	≥ 420	620 - 750	≥ 18	≥ 54	-

Materials

12 CrMoV9-10; SA 336 F22V; SA 541 Gr 22V

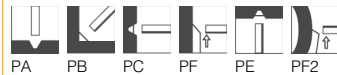
Storage and redrying

Keep dry and avoid condensation.

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

Current condition and welding position

DC+; AC



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
3,2	350	85 - 130	33,7	19,5
4,0	450	130 - 170	61,4	37,8
5,0	450	170 - 220	92,8	58,2