

# CROMOCORD 9

## MMA Electrodes Chromium-Molybdenum steels

CROMOCORD 9 is a basic coated, low hydrogen MMA electrode developed for the welding of creep resistant steels contain 9% Cr - 1% Mo. During welding preheat and interpass temperature controls between 250 - 300°C are recommended. Efficiency 100%.

Classification	
AWS	A5.5: E 8015-B8
EN	1599: E CrMo9 B 22 H5

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.07	0.68	0.40	≤ 0.015	≤ 0.015	8.30	0.06	0.90	-	-	-	-

### 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 750°C x 2h	≥ 460	≥ 590	≥ 20	≥ 47	-

### Materials

A335 Gr. P9

### 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	20,3	12,2
3,2	350	90-130	36,4	21,8
4,0	350	125-165	52,2	31,3
5,0	450	170-220	104,0	62,0