

MMA Electrodes Chromium-Molybdenum steels

Basic coated MMA electrode for welding high-temperature creep resistant steels of type 10Cr-1Mo-1W-V-Nb type. Particularly suited for thick-walled steel castings which are subjected to a tempering treatment of 12 hrs. at 730 °C. Vacuum packaging.

Classification

DIN 8575: -E CrMoW 10 B 20+

Approvals

Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.10	1	0.25	≤ 0.015	≤ 0.010	9.70	1	1	0.05	0.20	0.05	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) + 20 °C	Hardness
PWHT 730 °C x 12 h/furnace	≥ 550	700-820	≥ 17	≥ 75	-

Materials

G X 12 CrMoWVNbN 10 1 1

Storage and redrying

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 340-360 °C for 2 hours, 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)
3,2	350	80-130	38,4	23,0
4,0	450	140-180	76,5	46,0
5,0	450	180-230	116,7	70,0