

MMA Electrodes Chromium-Molybdenum steels

MOLYCORD Kb is a basic coated MMA electrode with a wide range of applications in the fabrication of vessels, boilers, pipes and for metal construction. Suitable for welding creep resistant steels, e.g. 16Mo3 as well as higher strength steels, yield strength <500 MPa. Creep resistant <530 °C, with good weld metal toughness down to -40°C. Very low hydrogen content. The double coating, 2.5 mm and 3.2 mm, confers a stable and concentrated arc even at low current intensity, well suited for root passes and positional welding. Welds are of X-ray quality.

Classification	
EN ISO	2560-A : E 50 4 Mo B 4 2 H5
EN ISO	3580-A: E Mo B 4 2 H5
AWS	A5.5: ~E 7018-A1-H4

Approvals	Grade
ABS	
DB	●
DNV	H10, NVO 3Mo (P)
RMRS	1Y (P)
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Mo
0.06	1	0.4	≤0.020	≤0.015	0.6

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-40 °C
As Welded	≥ 500	560-720	≥ 22	≥ 120	≥ 60
620 °C x 1 h	≥ 500	560-720	≥ 22	≥ 120	≥ 60

Materials

16Mo3, S(P)235-S(P)500

Storage

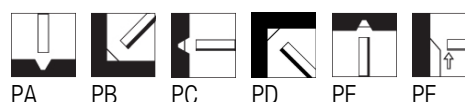
Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 340-360 °C for 2 hours, 5 times max.

HD ≤ 10: Re-dry at 300-350 °C for 2 hours, 5 times max

Current condition and welding position

DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX		VPMD	
				PC	Code	PC	Code
2.5	350	65-90	20.7	200	●	95	●
3.2	350	90-130	34.9	125	●	60	●
4.0	450	140-180	68.5	80	●	35	●
5.0	450	190-230	111.9	45	●	20	●