

MMA Electrodes Chromium-Molybdenum steels

OE-KV2HR is a low hydrogen iron-powder MMA electrode for the all-positional welding of steels containing 0.5%Mo and high tensile steels. Excellent weldability and arc stability, depositing weld metal with good X-ray quality and a high resistance to solidification cracking. Pre-heat and interpass temperatures between 100-150°C are recommended. Efficiency 120%.

Classification	
EN	3580-A: E Mo B 32 H5
AWS	A5.5: E 7018-A1 H4R
GOST	9467-75: Ø 09M

Approvals	Grade
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Mo
0.08	0.8	0.45	≤ 0.015	≤ 0.015	0.53

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-40 °C
620 °C x 1h	≥ 390	510-600	≥ 25	≥ 60

Materials

ASTM A355 Gr. P1; A182M Gr. F1

16Mo3; S(P)235-S(P)420

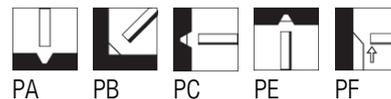
Storage

Keep dry and avoid condensation.

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

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX		VPMD	
				PC	Code	PC	Code
2.5	300	65-95	19.3	165	●	80	●
3.2	350	90-130	36.2	115	●	55	●
4.0	350	125-165	51.4	80	●	40	●
5.0	450	170-220	106.8	50	●	20	●