

## MMA Electrodes Chromium-Molybdenum steels

Basic coated MMA electrode depositing 1.25% Cr 0.5% Mo weld metal for the all-positional welding of creep resistant steels. OE-KV5HR is also recommended for welding 0.9%Cr 0.5%Mo steel. The chemical composition of the weld metal results in a high resistance to solidification cracking. Preheat and interpass temperatures 150-200°C are recommended. 120% recovery. X Factor <15ppm and J Factor <150ppm.

Classification	
EN	1599: E CrMo1 B 32 H5
AWS	A5.5: E 8018-B2 H4R
GOST	9467-75: ?09X1M similar

Approvals	Grade
TÜV	●

CE

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Mo
0.08	0.75	0.25	≤ 0.01	≤ 0.01	1.25	0.5

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-30 °C
690 °C x 1h	≥ 470	550 - 690	≥ 19	≥ 47

### Materials

A335 Gr P11; 13CrMo4-5; 13CrMoSi5-5

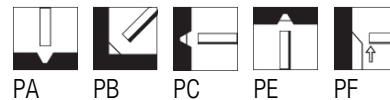
### Storage

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	19.7	165	●	80	●
3.2	350	90-130	35.9	115	●	55	●
4.0	350	125-165	52.7	80	●	40	●
5.0	450	170-220	104.6	50	●	20	●