

## MMA Electrodes Chromium-Molybdenum steels

OE-KV3L is a basic coated low hydrogen MMA electrode for the all positional welding of 2.25% Cr 1% Mo creep resisting steels. The low carbon content reduces the risk of cracking. In order to achieve the desired level of heat affected zone properties it is recommended that preheat and interpass temperatures of between 200-250°C are used. Efficiency 100%.

Classification	
EN	1599: E CrMo2L B 22 H5
AWS	A5.5: E 8015-B3L-H4

Approvals	Grade
RINA	C2M1 H5
TÜV	●

CE

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Mo
0.04	0.75	0.35	≤ 0.02	≤ 0.015	2.25	1


### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-20 °C
700 °C x 1h	≥ 460	630-720	≥ 18	≥ 47

### Materials

10CrMo9-10, 12CrMo9-10; A 387 Gr.22, Cl 1and 2, A 182 Gr.F 22, A 336 Gr.F22

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
DC+

PA PB PC PE PF

### Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX		VPM	
				PC	Code	PC	Code
2.5	300	65-95	19.3	165	●	80	●
3.2	350	90-130	35.0	115	●	55	●
4.0	350	125-165	51.4	80	●	40	●
5.0	450	170-220	98.2	60	●	25	●