

MMA Electrodes Chromium-Molybdenum steels

CROMO E225V is a basic coated MMA electrode for welding creep resistant steels of type 2.25%Cr - 1%Mo - V. The weld metal deposited is low in residual and impurity elements, which induce embrittlement, and therefore largely insensitive to in-service embrittlement, demonstrated by simulated heat treatment: STC = step cooling. X-factor <15ppm and J-factor <120.

Classification	
EN ISO	3580-B: E 6125-2C1MV H5
AWS	A5.5: E 9015-G

Approvals	Grade
ABS	E9015-G

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Mo	Nb	V
0.09	0.6	0.2	≤ 0.010	≤ 0.010	2.3	1	0.020	0.25


All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-30 °C
710°C x 8h	≥ 420	620 - 750	≥ 18	≥ 54

Materials

12 CrMoV9-10; SA 336 F22V; SA 541 Gr 22V

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 PD PE PF

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX		VPM	
				PC	Code	PC	Code
3.2	350	85-130	33.7	120	●	55	●
4.0	450	130-170	61.4	90	●	40	●
5.0	450	170-220	92.8	55	●	25	●