

## MMA Electrodes Chromium-Molybdenum steels

CROMOCORD 5 is a basic coated MMA electrode for creep resistant steels of type 5%Cr - 0.5%Mo. Applications include the welding of boilers, pressure vessels, pipework etc., with operating temperatures <650°C.

Classification	
EN ISO	3580-A: E CrMo5 B 2 2 H5
AWS	A5.5: E 8015-B6-H4
EN 1599	E CrMo5 B 2 2 H5

Approvals	Grade
TÜV	●

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Mo
0.07	0.8	0.3	≤ 0.012	≤ 0.010	5	0.5

### All-weld metal Mechanical Properties







Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-10 °C
	≥ 460	600-700	≥ 19	≥ 100	≥ 80
960 °C x 0.5h/air + 710 x 2h	≥ 580	650-750	≥ 17	≥ 100	≥ 80

### Materials

A 336 Cl. F5, A 369 Gr. FP5, A 387 Gr.5, Cl 1, Cl 2

12CrMo19-5, X12CrMo5; A182 Gr. F5, A199 Gr. T5, A213 Gr.T5, A335 Gr.P5

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)	VPMD	
				PC	Code
2.5	300	65-95	18.9	90	●
3.2	350	90-130	36.5	55	●
4.0	350	125-165	52.4	40	●
5.0	450	170-220	97.2	25	●