

MMA Electrodes C-Mn and low-alloy steels

OE CRYO 87 deposits weld metal containing 3,5%Ni and is suitable for welding fine grain steels. Used for welding steels operating at temperatures down to -101°C. Suitable for welding pipes, tanks, containers. Efficiency 100%.

Classification

EN ISO	2560-A: E 42 6 3Ni B 12 H5
AWS	A5.5: E 7016-C2L
GOST	9467-75: ?50A-E51 7

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni
0.03	0.5	0.2	≤ 0.02	≤ 0.02	3.5

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-101 °C
As Welded	≥ 420	500-640	≥ 25	≥ 47
620 °C x 1h	≥ 420	≥ 460	≥ 25	≥ 60

Materials

ASTM A203 gr. B; A333/ A334 gr. 3; 12Ni14

Storage

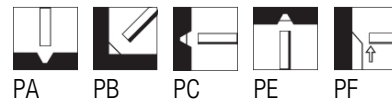
Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 400-420 °C for 1 hour, 5 times max

HD ≤ 10: Re-dry at 350-370 °C for 1 hour, 5 times max

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	VPMD	
				PC	Code
2.5	300	60-90	18.5	90	●
3.2	350	90-140	34.9	60	●
4.0	350	120-180	53.5	40	●
5.0	450	190-250	94.9	25	●