

MMA Electrodes Chromium-Molybdenum steels

Basic coated electrode of the 1,5 Cr - 1 Mo - 0,25 V type, designed for welding cast steel of identical composition, with operating temperatures of up to +600 °C. Observe specifications for preheating and post-weld heat treatment of the base plates.

Classification	
AWS	A5.5: E 9015-G
EN	1599: E CrMoV 1 B 42 H10

Approvals	Grades
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.12	0.90	0.40	≤ 0.015	≤ 0.010	1.40	-	1	-	0.25	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) + 20 °C	Hardness
PWHT 680 °C x 8 h/air	≥ 450	600-800	≥ 15	≥ 47	-

Materials

G17CrMoV5-11

Storage and redrying

Keep dry and avoid condensation.

HD ≤ 10: Re-dry at 300-350 °C for 2 hours, 5 times max

Current condition and welding position

DC+



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	350	60-90	21,0	12,6
3,2	450	90-130	46,0	27,6
4,0	450	140-180	70,0	42,0
5,0	450	190-230	106,0	63,6