

CHROMET 92

MMA (SMAW)

MMA ELECTRODE FOR WELDING P92 CREEP RESISTING STEELS

PRODUCT DESCRIPTION

Basic coated MMA electrode made on matching core wire. Moisture resistant coatings giving very low weld metal hydrogen levels.

Recovery is approximately 120% with respect to core wire, 65% with respect to the whole electrode.

CLASSIFICATIONS

AWS A5.5M	E9015-B92 H4
ISO 3580-A	E ZCrMoWVNb 9 0.5 2 B 3 2 H5
APPROVALS	TÜV

ASME IX QUALIFICATION

QW422	P-No 15E group 1
QW432	F-No 4
QW442	A-No 5

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn*	Si	S	P	Cr	Ni*	Mo	W	Nb	V	N	B	Al	Cu
min.	0.08	0.40	--	--	--	8.0	--	0.30	1.5	0.04	0.15	0.03	0.001	--	--
max.	0.13	1.00	0.40	0.015	0.020	9.5	0.80	0.60	2.0	0.07	0.25	0.07	0.005	0.03	0.15
Typical	0.11	0.6	0.25	0.01	0.01	9	0.5	0.45	1.7	0.05	0.2	0.05	0.003	<0.01	<0.05

* Mn + Ni ≤ 1.2%

ALL-WELD MECHANICAL PROPERTIES

Properties after PWHT	Min.*	Typical [760°C / 2-4h]			
		20°C	550°C	600°C	650°C
Tensile strength (MPa)	620	740	511	422	340
0.2% proof strength (MPa)	530	630	419	320	229
Elongation (%) 4d	17	22	15	19.5	19.5
5d	16	19	14	18	18
Reduction of area %	--	50	64	73	80
Impact ISO-V(J) +20°C	--	60	--	--	--
Hardness (HV) PWHT	--	230-260	--	--	--

OPERATING PARAMETERS, DC +VE OR AC (OCV: 70V MIN)

Diameter (mm)	2.5	3.2	4.0	5.0
min. A	60	80	100	140
max. A	90	120	160	220

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				can	box	can	box
METAL CAN	2.5	300	CH92-25	225	675	3.9	11.7
	3.2	350	CH92-32	122	366	4.3	12.9
	4.0	350	CH92-40	83	249	4.5	13.5
	5.0	450	CH92-50	Consult us			

Redrying : 250 – 300°C/1-2h to ensure H₂ < 10ml/100g, 300 – 350°C/1-2h to ensure H₂ < 5ml/100g. Maximum 420°C, 3 cycles, 10h total.

FUME DATA (WT % TYPICAL)

Fe	Mn	Ni	Cr	Cu	Pb	F	OES (mg/m ³)
15	5	< 0.1	< 3	< 0.1	< 0.1	18	1.7

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.specialalloys.eu for any updated information.