

CHROMET 9

MMA (SAW)

9Cr-1Mo CREEP RESISTING STEEL MMA ELECTRODE

PRODUCT DESCRIPTION

Basic metal powder type made on high purity low carbon core wire. Moisture resistant coating giving very low weld metal hydrogen levels.

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

CLASSIFICATIONS

AWS A5.5M	E8015-B8 H4
ISO 3580-A	E CrMo9 B 3 2 H5
ISO 3580-B	E 6216-9C1M

ASME IX QUALIFICATION

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	Cu
min.	0.05	0.50	--	--	--	8.0	--	0.90	--
max.	0.10	1.00	0.60	0.025	0.025	10.0	0.40	1.20	0.3
Typical	0.06	0.75	0.35	0.012	0.015	9.0	0.2	1.0	<0.05

ALL-WELD MECHANICAL PROPERTIES

Properties after PWHT*	Min.	Typical	
		740°C/2h	746°C/3h
Tensile strength (MPa)	590	710	680
0.2% proof strength (MPa)	530	600	550
Elongation [%] 4d	19	22	26
5d	18	20	25
Reduction of area %	--	70	70
Impact ISO-V(J) +20°C	34	90	130
0°C	--	50	--
-10°C	--	25	90
Hardness (HV)	--	235	220

* PWHT : AWS is 740 +/- 15°C /1, ISO 3580-A is PWHT is 740-780°C/2h. See front page under PWHT for normal fabrication practice.

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

Diameter (mm)	2.5	3.2	4.0
min. A	70	80	100
max. A	110	140	180

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				can	box	can	box
METAL CAN	2.5	350	CHROMET9-25	203	609	4.5	13.5
	3.2	350	CHROMET9-32	128	384	4.4	13.2
	4.0	450	CHROMET9-40	91	273	6.0	18.0

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/m³)
15	5	<0.1	2.5	<0.2	<0.1	18	2

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.