

1NiMo.B**MMA (SMAW)****ALL-POSITIONAL STEEL MMA ELECTRODE FOR WELDING OF WB36/P36 STEELS****PRODUCT DESCRIPTION**

MMA electrode with a basic flux coating on high purity mild steel core wire. Moisture resistant coating provides 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	E9018-G H4
ISO 18275-A	E 55 41NiMo B 3 2 H5
APPROVALS	TÜV

ASME IX QUALIFICATION

QW432	F-No 4
QW442	A-No 10

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	V
min.	0.05	1.0	--	--	--	--	0.8	0.20	--	--
max.	0.12	1.4	0.5	0.020	0.025	0.3	1.2	0.50	0.10	0.03
Typical	0.07	1.2	0.3	0.01	0.01	0.1	1.0	0.4	0.05	0.01

ALL-WELD MECHANICAL PROPERTIES

Properties after PWHT	Min.	Typical (590-620°C /1-2h)			
		20°C	250°C	350°C	450°C
Tensile strength (MPa)	620	744	650	640	545
0.2% proof strength (MPa)	550	677	505	445	432
Elongation (%) 4d	17	25	22	28	24
5d	--	22	--	--	--
Reduction of area %	--	65	57	69	73
Impact ISO-VU) 0°C	--	130			

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

Diameter (mm)	2.5	3.2	4.0	5.0
min. A	70	80	100	140
max. A	110	140	180	240

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				can	box	can	box
METAL CAN	2.5	350	1NIMOB-25	186	558	4.3	12.9
	3.2	350	1NIMOB-32	124	372	4.5	13.5
	4.0	450	1NIMOB-40	80	240	5.6	16.8
	5.0	450	1NIMOB-50	57	171	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	F	OES (mg/m³)
14	5	0.5	<0.1	<0.2	18	5

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.