

CHROMET 12MV

MMA (SMAW)

BASIC ALL-POSITIONAL MMA ELECTRODE C

PRODUCT DESCRIPTION

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

Recovery is about 130% with respect to core wire, 65% with respect to the whole electrode.

CLASSIFICATIONS

ISO 3580-A E CrMoWV12 B 3 2 H5

ASME IX QUALIFICATION

QW432 F-No --

QW442 A-No --

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	V
min.	0.15	0.40	--	--	--	10.0	--	0.80	0.40	0.20
max.	0.22	1.30	0.80	0.025	0.025	12.0	0.8	1.20	0.60	0.40
Typical	0.20	0.8	0.25	0.010	0.017	11	0.5	1	0.5	0.3

ALL-WELD MECHANICAL PROPERTIES

Properties after PWHT(760°C / 3h)	Room temperature		Elevated temperature					
	min *	typical	350°C		400°C		450°C	
			min	typ	min	typ	min	typ
Tensile strength (MPa)	690	750	--	590	--	560	--	520
0.2% proof strength (MPa)	550	550	370	450	355	420	325	410
Elongation (%) 4d	--	24	--	18	--	20	--	17
5d	15	21	--	16	--	16	--	14
Reduction of area %	--	55	--	50	--	48	--	48
Impact ISO-V(U) +20°C	34	40	--	--	--	--	--	--
0°C	--	33	--	--	--	--	--	--
Hardness (HV)	--	235	--	--	--	--	--	--

* Minimum requirements after PWHT of 740-780°C/2 hours.

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	CH12MV-25	Consult us			
	3.2	350	CH12MV-32				
	4.0	450	CH12MV-40				
	5.0	450	CH12MV-50				

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	Mo	V	F	OES (mg/m ³)
20	4	0.1	3	<0.2	0.1	0.1	16	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.