

CHROMET 1 (SL 19G)

MMA (SMAW)

1¼Cr-½Mo CREEP RESISTING STEEL MMA ELECTRODE

PRODUCT DESCRIPTION

MMA electrode meeting AWS and ISO standards suitable for most power generation applications.

Basic flux, metal powder type coatings on low carbon high purity core wire. Recovery is approximately 115% with respect to the core wire and 65% with respect to the whole electrode. Moisture resistant coating gives very low metal hydrogen levels.

CLASSIFICATIONS

AWS A5.5M	E8018-B2
ISO 3580-A	E CrMo1 B 3 2 H5
ISO 3580-B	E 5518-1CM
APPROVALS	TÜV

ASME IX QUALIFICATION

QW432	F-No 4
QW442	A-No 3

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	Mo	Ni	Cu	Nb
Min.	0.05	0.50	--	--	--	1.00	0.45	--	--	--
Max.	0.12	0.90	0.80	0.025	0.030	1.40	0.65	0.3	0.2	0.01
Typical	0.07	0.8	0.5	0.01	0.02	1.25	0.55	0.1	<0.1	0.01

ALL-WELD MECHANICAL PROPERTIES

Properties after PWHT:	Min.	Typical 690°C/1h
Tensile strength (MPa)	550	640
0.2% proof strength (MPa)	460	570
Elongation (%) 4d	19	25
5d	20	24
Reduction of area %	--	70
Impact ISO-V(J) +20°C	47	160
Hardness (HV)	--	210

TYPICAL 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)	
				pack	carton	pack	carton
METAL CAN	2.5	350	CHROMET1-25-1	195	585	4,0	12,0
	3.2	350	CHROMET1-32-1	112	336	4,1	12,3
	4.0	450	CHROMET1-40-1	77	231	5,4	16,2

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	Cr	Ni	Cu	F	OES (mg/m³)
15	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.