

CHROMET WB2

MMA (SMAW)

MMA ELECTRODE FOR C(F)B2 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 approx 120% with respect to core wire, 65% with respect to the whole electrode.

CLASSIFICATIONS

AWS A5.5M

E9015-G H4

ASME IX QUALIFICATION

QW422 P-No 15E group 1

QW432 F-No 4

QW442 A-No 2

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	Nb	V	N	B	Co
min.	0.10	0.40	0.15	--	--	9.0	0.40	1.4	0.04	0.20	0.001	0.003	0.80
max.	0.15	1.00	0.50	0.015	0.020	10.5	0.80	1.7	0.07	0.30	0.035	0.010	1.20
Typical	0.12	0.6	0.25	0.009	0.010	9.5	0.6	1.5	0.05	0.25	0.02	0.005	1.0

ALL-WELD MECHANICAL PROPERTIES

PWHT (760°C / 4h or equivalent)	Min.	Typical 760°C/4h	Typical 760°C/10h	High Temperature *		
				+600°C	+650°C	+700°C
Tensile strength (MPa)	650	735	730	425	325	256
0.2% proof strength (MPa)	530	600	590	320	240	135
Elongation (%) 4d	17	23	21	21	34	30
5d	15	21	19	19	31	28
Reduction of area %	--	58	56	71	80	85
Impact ISO-V(I) +20°C	--	40	40	--	--	--
Hardness (HV)	--	230-260	230-260	--	--	--

* After PWHT at 730°C/12h + 730°C/12h.

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

Diameter (mm)	3.2	4.0	5.0	6.0
min. A	80	100	140	200
max. A	130	170	240	300

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				can	box	can	box
METAL CAN	3.2	350	CHWB2-32	122	366	4.3	12.9
	4.0	350	CHWB2-40	83	249	5.6	16.8
	5.0	450	CHWB2-50	53	159	5.6	16.8

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.