

THERMET 800Nb

MMA (SMAW)

BASIC MMA ELECTRODE TO MATCH ALLOY 800

PRODUCT DESCRIPTION

MMA electrode – Basic moisture resistant coated electrode made on high alloy, high purity core wire.
Recovery is about 120% with respect to core wire, 65% with respect to whole electrode.

CLASSIFICATIONS

There are no national specifications for this electrode.

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	Nb	Cu
min.	0.06	1.6	--	--	--	19.0	30.0	--	0.8	--
max.	0.12	4.5	0.6	0.02	0.03	23.0	35.0	0.5	1.5	0.5
Typical	0.1	2.5	0.3	0.007	0.015	21	32	0.4	1.3	0.15

ALL-WELD MECHANICAL PROPERTIES

As welded	Min. *	Typical
Tensile strength [MPa]	520	615
0.2% proof strength [MPa]	210	410
Elongation [%] 4d	--	> 33
5d	25	> 32
Reduction of area [%]	--	46
Impact ISO-V(J) + 20°C	--	> 55
Hardness (HV)	--	170-220

* Minimum tensile properties based on wrought alloy 800H.

OPERATING PARAMETERS, DC +VE ONLY

Diameter (mm)	2.5	3.2	4.0	5.0
min. A	60	75	100	130
max. A	90	120	155	210

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				can	box	can	box
METAL CAN	2.5	300	TH800NB-25	CONSULT US			
	3.2	350	TH800NB-32				
	4.0	320	TH800NB-40				

Redrying : 150 – 200°C/1-2h to restore to as-packed condition. Maximum 350° C, 3 cycles, 10h total

FUME DATA (WT % TYPICAL)

Fe	Mn	Cr	Ni	Mo	Cu	F	OES (mg/m³)
4	6	6	2	< 0.2	< 0.2	18	0.8

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.