

CHROMET 1L

MMA (SMAW)

LOW ALLOY STEELS

LOW CARBON 1¼Cr-½Mo MMA ELECTRODE

PRODUCT DESCRIPTION

MMA electrode – 1¼Cr-½Mo deposit with low carbon which produces lower hardness and residual stresses for resistance to sulphide stress corrosion cracking when operating in wet 'sour' environments. Also suitable for thin section joints which are to be left in the as-welded condition.

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	E7015-B2L H4
ISO 3580-A	E CrMo1L B 3 2 H5
ISO 3580-B	E 5216-1CML

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	Cu
Min.	0.03	0.50	--	--	--	1.00	0.45	--
Max.	0.05	0.90	0.80	0.025	0.025	1.40	0.65	0.15
Typical	0.04	0.80	0.40	0.012	0.015	1.25	0.55	<0.10

ALL-WELD MECHANICAL PROPERTIES

Properties after PWHT or AWS:	Min.	Typical	
		AWS	690°C/1h
Tensile strength (MPa)	520	650	600
0.2% proof strength (MPa)	390	570	500
Elongation (%) 4d	19	27	26
	5d	20	23
Reduction of area %	-	-	68
Impact ISO-V(J) +20°C	-	130	180
	-10°C	-	120
Hardness (HV)	-	220	200

OPERATING PARAMETERS, DC +ve or AC (OCV: 70V Min)

Diameter (mm)	3.2
min. A	80
max. A	140

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				can	box	can	box
METAL CAN	3.2	350	CHROMET1L-32	126	378	4.5	13.5

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

FUME DATA (WT % TYPICAL)

Fe	Mn	Cr	Ni	Cu	F	OES (mg/m ³)
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.