



P 62MR

SMAW - (Stick) - MMA
Low-alloyed

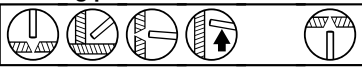
Date:	2009-06-05
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Description:

P 62MR is a basic-coated low hydrogen electrode producing a nominal 0.9% Ni weld metal, designed to give excellent fracture toughness at temperatures down to -60 °C. It is an AC/DC electrode with optimised welder-appeal, especially in the vertical up position, producing a finely rippled bead surface and good slag detachability.

Electrode sizes 3,2x350 mm also available with a thin coating, "tc", ideally suited for root pass welding and joints with restricted access. P 62MR conforms to NACE requirements for oil and gas production equipment in sour service and has excellent CTOD values, making it highly suitable for offshore applications.

Welding positions:



Coating type:

Basic

Welding current:

DC+/-, AC OCV ≥ 70 V, For root passes: DC -

Hydrogen content / 100 g weld metal

≤ 5 ml

Metal recovery:

110-120%

Redrying temperature:

350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,20	1,05				0,8
Typical	0,06	0,3	1,3	0,01	0,005		0,9
Max	0,08	0,50	1,60	0,015	0,015	0,1	1,0

	Mo	Cu	V	Nb
Min				
Typical				
Max	0,1	0,2	0,05	0,05

Mechanical properties

	<u>Specified</u>	<u>Typical</u>	<u>PWHT Typical</u>
Yield strength, Re:	≥460 MPa	530 MPa	500 MPa
Tensile Strength, Rm:	530-650 MPa	610 MPa	580 MPa
Elongation, A5	≥ 23%	25%	23%
Impact energy, CV:	-50 °C • ≥47 J	-60 °C • 60 J	-50 °C • 70 J 600°C x 1h

Classification:

EN 499	~E 46 5 1Ni B 32 H5
EN ISO 2560-A	~E 46 5 1Ni B 32 H5
AWS A5.5	E7018-G / (E 8018-G)**

Approvals:

MRS	5Y42 H5
BV	3Y HHH
LR	3m, 5Y 42m H5
CE	
NAKS	
ABS	3Y
DNV	5Y46 H5

Note

(PWHT: 620 °C, 2h: -20 °C 150J, -46 °C 70J, -60 °C 40J)
CTOD -10 °C > 0.25 mm
Part no. 7162-2500, -3250: thin coating.

EN: slight deviation in Mn

** Meet also 8018-G in dia up to 4,0 mm

Core wire:

S ≤ 0.015%

P ≤ 0.015%

N ≤ 0.008%

Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,5	350	71622500	60-110	22	0,73	71	0,8	54
3,2 tc	350	71623250	80-155	23	0,72	42	1,3	54
3,2	350	71623235	80-150	24	0,71	37	1,4	58
3,2	450	71623200	80-150	24	0,71	28	1,4	82
4,0	450	71624000	140-200	24	0,72	19	1,9	89
5,0	450	71625000	200-270	24	0,72	13	2,6	100

