SUPERCORD 45

OERLIKON

MMA Electrodes
C-Mn and low-alloy steels

Medium-coated rutile electrode, suitable for all positional welding, except vertically down. The arc is stable even with welding equipment on low open circuit voltage; particularly suitable for tack welding applications on dirty or primed plate. Efficiency 100%.

Classification	
AWS	A5.1: E6013
EN	499: E 42 0 R 12
EN ISO	2560-A: E 42 0 R 12

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.09	0.65	0.40	≤ 0.030	≤ 0.030	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm^2	Tensile Strength N/mm^2	Elongation A5 (%)	Impact Energy ISO - V (J) 0°C	Hardness
As Welded	≥ 420	500 - 640	≥ 20	≥ 47	-

Materials

S(P)235 to S(P)355; GP240; GP280

Storage and redrying

Keep dry and avoid condensation. Re-drying not generally required. If necessary: 100-110 °C for 1 hour.

Current condition and welding position

AC; DC-

Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
1,5	250	25-50	5,7	3,6
2,0	300	40-70	11,0	6,3
2,5	300	60-90	17,7	10,4
3,2	450	90-130	44,3	26,5