

MMA Electrodes C-Mn and low-alloy steels

General-purpose rutile coated electrode for structural steelwork, workshop and maintenance welding with easy operability. Good gap-bridging. Smooth welds, self-releasing slag.

Classification	
AWS	A5.1: E6013
EN ISO	2560-A: E 42 A R 11

Approvals	Grades
ABS	
BV	
DNV	
GL	
LRS	

see Appendix, Classification Society Approvals, for details pag. 521

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.07	0.50	0.40	-	-	-	-	-	-	-	-	-

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	≥ 450	510-600	≥ 20	≥ 25	-

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

DC-; AC



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	62-85	15,4	9,3
3,2	350	100-125	29,1	17,5
4,0	350	130-170	42,6	25,6
5,0	450	170-210	94,9	65,0