

MMA Electrodes C-Mn and low-alloy steels

Rutile-coated electrode particularly suited for the welding of horizontal fillets. Fine-droplet metal transfer. Easy arc striking and restriking. Very smooth welds blending into the base metal without undercut. Slag in most cases self-releasing. For but-welds Fincord or Fincord DB should be used.

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

Approvals	Grades
DB	
TÜV	

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
0.08	0.60	0.50	-	-	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

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

Materials

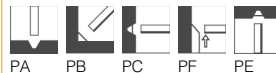
S(P)235 to S(P)355; GP240; GP280

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)
2,5	350	65-90	21,0	10,6
3,2	350	100-140	35,9	18,3
3,2	450	100-140	47,0	24,4
4,0	450	140-180	69,8	37,3
5,0	450	190-240	107,8	58,0