

MMA Electrodes C-Mn and low-alloy steels

Rutile coated electrode with an efficiency of 130 %, designed for welding butt and fillet seams. Using a 4mm diameter electrode, fillet welds with a throat thickness of 3 mm can be achieved, working at high travel speeds. Easy arc striking and restriking, clean and smooth welds blending into the base metal without undercut. Low spatter loss and easy slag removal.

Classification	
AWS	A5.1: E7024
EN	499: E 42 0 RR 53
EN ISO	2560-A:E 42 0 RR 53

Approvals	Grades
ABS	
BV	
DNV	
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
0.10	0.80	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) + 20 °C	Hardness
As Welded	≥ 420	510-610	≥ 22	≥ 60	-

Materials

S(P)235-S(P)420, 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-; DC+; AC



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
3,2	450	140-160	63,7	38,2
4,0	450	180-230	89,6	53,8
5,0	450	230-280	139,5	82,5