

MMA Electrodes C-Mn and low-alloy steels

Rutile coated electrode with an efficiency of approx. 160 %. It is designed for butt and fillet welds and is used for economically filling large weld sections and making long fillet welds. Easy arc striking and restriking. It produces very smooth and clean welds, merging into the base metal without undercut. Low spatter loss and easy slag removal, with proper current setting the slag is self releasing. Due to low generation of fumes, ideal for use in confined spaces.

Classification	
AWS	A5.1: E7024
EN	499: E 42 0 RR 73
EN ISO	2560-A: E 42 0 RR 73

Approvals	Grades
ABS	
BV	
DB	
DNV	
GL	
LRS	
RS	
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
0.10	0.90	0.45	-	-	-	-	-	-	-	-	-

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	71,1	42,7
4,0	450	180-230	107,8	64,7
5,0	450	260-340	148,1	88,9