

## MMA Electrodes C-Mn and low-alloy steels

Rutile coated electrode with an efficiency of approx. 180 %, used to produce long fillet welds and economically filling thick sections. Relatively low current intensities and short burn-off times.

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	0.40	-	-	-	-	-	-	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	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	130-160	71,0	42,6
4,0	450	180-230	105,2	63,1
5,0	450	260-310	159,0	95,4