

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

Rutile coated high-efficiency electrode with an efficiency of approx. 200 %. 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, without undercut. Low spatter loss and self-releasing slag.

Classification	
AWS	A5.1: E7024
EN	499: E 42 2 RR 73
EN ISO	2560-A: E 42 2 RR 73

Approvals	Grades
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
0.07	1.10	0.60	-	-	-	-	-	-	-	-	-

### 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	180-230	81,3	48,8
4,0	450	230-280	108,0	64,8
5,0	450	280-320	166,0	99,6