CITORAPID

OERLIKON

MMA Electrodes
C-Mn and low-alloy steels

Acid-rutile coated electrode featuring a high melt-off rate due to its very high current carrying capacity. Therefore, it is particularly suited for piece work applications. Concave, smooth weld beads. Very easy slag removal from fillet welds and even from acute bevel angles. Full root penetration in fillet welds. It is suitable for welding galvanized, primer painted and slightly rusted parts. Due to the low-Si-content, suitable for subsequent galvanizing, enamelling and rubber cladding. Weld joints are of X-ray quality.

Classification	
AWS	A5.1: E6020
EN	499: E 38 2 RA 13
EN ISO	2560-A: E 38 2 RA 13

Approvals	Grades
ABS	
BV	
DB	
LRS	
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	0.20	-	-	-	-	-	-	-	-	-

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	≥ 380	470-600	≥ 20	≥ 60	-

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-

PA PB

Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	350	60-90	19,3	11,6
3,2	450	90-160	42,3	24,7
4,0	450	130-220	64,0	37,8
5,0	450	180-300	99,8	59,0
6,0	450	250-340	145,7	87,0