

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

Acid-rutile coated electrode with an efficiency of approx. 165 %. It produces very smooth welds without undercut. Slag is easily removed, even from acute bevel angles. It is suitable for welding galvanized, primer painted and slightly rusted components. Welds are of X-ray quality.

| Classification |                      |
|----------------|----------------------|
| AWS            | A5.1: E6027          |
| EN             | 499: E 38 2 RA 73    |
| EN ISO         | 2560-A: E 38 2 RA 73 |

| Approvals | Grades |
|-----------|--------|
| ABS       |        |
| BV        |        |
| DB        |        |
| DNV       |        |
| GL        |        |
| 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 |
|------|------|------|---|---|----|----|----|----|---|---|----|
| 0.06 | 0.80 | 0.25 | - | - | -  | -  | -  | -  | - | - | -  |

### All-weld metal Mechanical Properties

| Heat Treatment | Yield Strength<br>N/mm <sup>2</sup> | Tensile Strength<br>N/mm <sup>2</sup> | Elongation<br>A5 (%) | Impact Energy<br>ISO - V (J)<br>- 20 °C | Hardness |
|----------------|-------------------------------------|---------------------------------------|----------------------|---|----------|
| As Welded      | ≥ 380                               | 470-600                               | ≥ 20                 | ≥ 47                                    | -        |

### 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-**



### Packaging data

| Diameter<br>(mm) | Length<br>(mm) | Current<br>(A) | Electrode<br>average weight (g) | Weld metal weight<br>per electrode (g) |
|------------------|----------------|----------------|---------------------------------|--|
| 4,0              | 450            | 170-220        | 97,0                            | 71,0                                   |
| 5,0              | 450            | 250-220        | 153,0                           | 111,0                                  |