

MMA Electrodes C-Mn and low-alloy steels

Rutile electrode for all positional welding. Easy to use on dirty or poorly prepared base plates. Efficiency 100%.

Classification	
AWS	A5.1: E6013
DIN	499: E 38 0 RC 11
EN ISO	2560-A: E 38 0 RC 11

Approvals	Grades
ABS	
BV	
DB	
DNV	
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	0.80	0.50	≤ 0.030	≤ 0.030	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 0°C	Hardness
As Welded	≥ 380	470-600	≥ 20	≥ 47	-

Materials

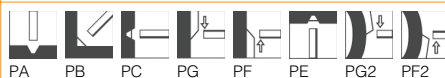
S(P)235 to S(P)355; GP240; GP280

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

DC-



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
1,6	300	25-45	7,1	4,0
2,0	350	50-60	11,3	6,9
2,5	350	60-90	16,8	10,7
3,2	350	100-140	26,9	16,4
3,2	450	100-140	35,0	22,1
4,0	350	150-190	43,0	27,1
4,0	450	150-190	55,4	36,2
5,0	450	190-240	89,3	51,1