

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

Rutile electrode for welding in all positions. Excellent fusion and good bead aspect. Used with all types of welding equipment even with low OCV. Efficiency 100%.

Classification	
AWS	A5.1: E6013
EN	499: E 35 0 RC 11
EN ISO	2560-A: E 35 0 RC 11

Approvals	Grades

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.10	1	0.50	≤ 0.030	≤ 0.030	-	-	-	-	-	-	-

### 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) 0°C	Hardness
As Welded	≥ 355	440-570	≥ 24	≥ 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



### Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
1,6	300	30-35	7,0	3,2
2,0	350	55-60	11,0	7,1
2,5	350	60-75	18,0	10,6
3,2	350	100-110	29,0	16,6
3,2	450	100-110	37,0	22,3
4,0	350	150-170	43,0	27,5
4,0	450	150-170	55,0	35,6
5,0	450	200-230	99,0	71,8