

MMA Electrodes C-Mn and low-alloy steels

Rutile coated general-purpose electrode for welding of structural steelwork, and light industrial applications. It is suited for welding in all positions, also for tack welding. Easy arc striking and restriking. Smooth weld beads blending into base metal without undercutting. Self releasing slag.

Classification	
AWS	A5.1: E 6013
EN	499:E 38 0 RC 11
EN ISO	2560-A: E 38 0 RC 11

Approvals	Grades
DB	
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	0.40	-	-	-	-	-	-	-	-	-

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	≥ 22	≥ 60	-

Materials

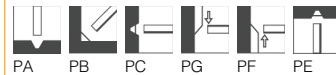
S(P)235 to S(P)355; GP240; GP280

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-



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	350	55-85	18,3	10,35
3,2	350	90-135	30,1	18,2
4,0	350	130-170	44,8	26,35