

MMA Electrodes C-Mn and low-alloy steels

Rutile-basic coated electrode which is particularly suitable for welding root passes and for positional welding in the fabrication of pipes, boilers and tanks. It is also suitable for depositing backing beads in submerged-arc welding. Due to its low Si-content, the weld metal is suited for subsequent galvanizing or enamelling. For welding cover passes the use of FINCORD DB electrodes is recommended.

Classification	
AWS	A5.1: E6013
EN	499: E 38 2 RB 12
EN ISO	2560-A: E 38 2 RB 12

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
0.08	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	≥ 22	≥ 47	-

Materials

S(P)235 to S(P)355; GP240; GP280; L210 to L360

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-; AC



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,0	250	40-60	9,3	5,6
2,5	350	50-90	19,7	10,7
3,2	350	100-150	33,4	18,5
4,0	350	140-190	50,5	28,6
4,0	450	140-190	63,6	37,8
5,0	450	220-260	97,9	0,0