

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

Ultracito is a basic coated low hydrogen electrode for welding a range of mild and carbon-manganese steels. Depositing a C-1,2Mn weld metal, the addition of metal powder to the coating gives a nominal efficiency of 110%. Ultracito is a versatile electrode for welding both thin plate and heavy sections especially in deep or restricted configurations. The electrode is particularly suited to fillet welding where excellent mitre finish beads are obtained. Ultracito is an all-positional electrode exhibiting a very stable arc with good control of the molten weld pool. Suitable for use with either AC (minimum OCV of 70V) or DC positive and negative.

### Classification

AWS	A5.1: E7018
EN	499: E 42 2 RB 32 H10
EN ISO	2560-A: E 42 2 RB 32 H10

### Approvals

### Grades

ABS
BV
DNV
LRS

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
0.05	1.20	0.30	≤ 0.025	≤ 0.020	-	-	-	-	-	-	-

### 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) -20°C	Hardness
As Welded	≥ 420	500-640	≥ 24	≥ 80	-

### Materials

S(P)235-S(P)420, GP240-GP280

### Storage and redrying

Keep dry and avoid condensation.

HD ≤ 10: Re-dry at 300-350 °C for 2 hours, 5 times max

### Current condition and welding position

DC+; DC-; AC



### Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	60-90	23,8	14,3
3,2	350	100-135	36,2	21,7
4,0	450	140-190	67,9	40,7
5,0	450	180-235	100,8	60,5