

MMA Electrodes C-Mn and low-alloy steels

Basic coated multi purpose electrode for assembly work, workshop and maintenance welding, approved for rail joint welding. Smooth and clean welds without undercut. Good gap bridging properties. Owing to its double coating this electrode has a stable and concentrated arc and is suited for AC welding. Good suitability for root pass and positional welding. Welds are of X-ray quality.

Classification	
AWS	A5.1: E7016-H8
EN	499: E 42 4 B 32 H 10
EN ISO	2560-A: E 42 4 B 32 H10

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	1.30	0.45	≤ 0.020	≤ 0.015	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 40 °C	Hardness
As Welded	≥ 420	500-640	≥ 25	≥ 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+, AC



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	350	60-90	19,6	11,7
3,2	350	90-140	32,8	20,2
4,0	450	135-190	64,0	41,3
5,0	450	190-260	100,2	64,0