

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

Basic coated electrode which deposits low tensile strength weld metal with excellent toughness. It is suitable for welding restrained structural members and large weld cross sections.

Classification	
EN	499: E 35 6 B 42 H 5
EN ISO	2560-A: E 35 6 B 42 H5

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
0.07	0.90	0.40	≤ 0.020	≤ 0.015	-	-	-	-	-	-	-

### 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) - 60 °C	Hardness
As Welded	355-430	440-550	≥ 25	≥ 100	-

### Materials

S(P)235-S(P)355, GP240-GP280; L245-L290

### Storage and redrying

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 340-360 °C for 2 hours, 5 times max.

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	60-85	19,5	11,7
3,2	350	90-140	33,6	20,0
4,0	450	140-190	67,5	40,5