

MMA Electrodes C-Mn and low-alloy steels

Basic coated special electrode for joint-welding of rails of different sections. It permits continuous welding without intermediate slag removal. Due to its double coating, it features a stable and concentrated arc.

Classification	
EN	499: E 46 6 B 34 H 10
EN ISO	2560-A: E 46 6 B 34 H10

Approvals	Grades
DB	

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
0.06	1.80	0.70	≤ 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) - 60 °C	Hardness
As Welded	≥ 460	530-680	≥ 24	≥ 60	-

Materials

Rail steels.

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+



PA

Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
4,0	550	160-210	86,2	60,0
5,0	550	180-220	131,7	92,0
6,0	550	210-260	182,7	128,0