

MMA Electrodes C-Mn and low-alloy steels

Low hydrogen electrode with iron powder coating additions, suitable for welding C-Mn steels. High deposition rate, ideal for ship-building applications and general construction. Welds deposited with this electrode have excellent x-ray quality and very good impact toughness. Efficiency 120%.

| Classification | |
|----------------|------------------------|
| AWS | A5.1: E7018 |
| EN | 499: E42 4 B 32 H5 |
| EN ISO | 2560-A: E 42 4 B 32 H5 |

| Approvals | Grades |
|-----------|--------|
| | |

Analysis of all-weld metal (Typical values in %)

| C | Mn | Si | P | S | Cr | Ni | Mo | Nb | V | N | Cu |
|------|------|------|---------|---------|----|----|----|----|---|---|----|
| 0.08 | 1.30 | 0.40 | ≤ 0.020 | ≤ 0.020 | - | - | - | - | - | - | - |

All-weld metal Mechanical Properties

| Heat Treatment | Yield Strength N/mm ² | Tensile Strength N/mm ² | Elongation A5 (%) | Impact Energy ISO - V (J) -30°C | Hardness |
|----------------|-------------------------------------|---------------------------------------|----------------------|---------------------------------------|----------|
| As Welded | ≥ 420 | 500-640 | ≥ 22 | ≥ 47 | - |

Materials

S(P)235-S(P)420; GP240-GP280; L245-L360

Storage and redrying

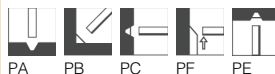
Keep dry and avoid condensation.

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+



Packaging data

| Diameter (mm) | Length (mm) | Current (A) | Electrode average weight (g) | Weld metal weight per electrode (g) |
|------------------|----------------|----------------|---------------------------------|--|
| 2,5 | 350 | 60-90 | 22,3 | 13,4 |
| 3,2 | 350 | 100-140 | 35,2 | 21,2 |
| 3,2 | 450 | 100-140 | 46,0 | 27,6 |
| 4,0 | 450 | 110-170 | 68,0 | 40,8 |
| 5,0 | 450 | 175-200 | 100,5 | 60,3 |