

MMA Electrodes C-Mn and low-alloy steels

Heavy basic coated electrode, designed for highly restrained work with static and dynamic loadings. Used in structural engineering, boilers, tanks and vehicle construction and also bridge building and shipbuilding. Recommended for service temperatures down to -40°C.

Classification	
AWS	A5.1: E7018-1
EN	499: E 42 5 B 32 H5
EN ISO	2560-A: E 42 5 B 32 H5

Approvals	Grades
ABS	
DNV	
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
0.06	1.50	0.30	≤ 0.025	≤ 0.025	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -50°C	Hardness
As Welded	≥ 430	490-550	≥ 24	≥ 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+; AC



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