

MMA Electrodes C-Mn and low-alloy steels

Basic coated electrode for producing tough and crack-free welded joints even on steels having a carbon content up to 0,4%. Weld metal recovery is approximately 120%. Good operating characteristics when positional welding. Weld metal has good toughness properties down to -50°C. Suitable for buffer layers.

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	
BV	
DB	
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
0.08	1.20	0.40	≤ 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) -50°C	Hardness
As Welded	≥ 420	510-610	≥ 24	≥ 90	-

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	40-60	21,7	13,0
3,2	350	100-135	34,9	21,0
4,0	450	110-170	66,5	40,0
5,0	450	170-220	104,3	63,0