

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

Basic coated electrode with a high Mn content of 1,5% and excellent weldability. Low Hydrogen content of the weld deposit; high mechanical properties and easy positional welding. Suitable for high yield strength steels. Efficiency 120%.

Classification	
AWS	A5.1: E 7018-1 H4
EN	499: E 42 5 B 32 H 5
EN ISO	2560-A: E 42 5 B 32 H5

Approvals	Grades
ABS	
DNV	
LRS	
MMI	
RINA	

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	1.50	0.40	≤ 0.020	≤ 0.020	-	-	-	-	-	-	-

### 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) -50°C	Hardness
As Welded	≥ 420	500 - 640	≥ 22	≥ 80	-

### Materials

S(P)235-S(P)420, GP240-GP280

### Storage and redrying

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 400-420 °C for 1 hour, 3 times max.

HD ≤ 10: Re-dry at 350-370 °C for 1 hour, 3 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	300	70-100	20,1	12,0
3,2	450	90-130	49,5	29,7
4,0	450	110-170	70,9	42,5
5,0	450	175-220	106,5	63,9
6,0	450	210-280	150,3	90,1