FEBACITO 160S

OERLIKON

MMA Electrodes
C-Mn and low-alloy steels

Basic coated electrode having an efficiency of approx. 165 %, used for welding fillets. Weld metal is very tough and free of cracks. Smooth and clean welds blending into base metal without undercut. Suitable for welding primer painted components. Slag is easily removable. Welds are of X-ray quality

Classification	
AWS	A5.1: E7028
EN	499: E 42 4 B53 H5
EN ISO	2560-A: E 42 4 B 53 H5

Approvals	Grades
ABS	
BV	
DB	
DNV	
GL	
LRS	
RS	
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
0.10	1.10	0.60	≤ 0.025	≤ 0.015	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm²	Tensile Strength N/mm²	Elongation A5 (%)	Impact Energy ISO - V (J) - 40 °C	Hardness
As Welded	≥ 420	510-610	≥ 26	≥ 80	-

Materials

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

Storage and redrying

Keep dry and avoid condensation.
HD < 5: Re-dry at 340-360 °C for 2 hours, 5 times max.

Current condition and welding position

AC; DC+

PA PB

Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
4,0	450	160-220	101,5	60,9
5,0	450	220-320	145,0	87,0