

MMA Electrodes C-Mn and low-alloy steels

Basic coated electrode for welding of steels with 3,5 % Ni with good impact toughness at -105 °C. This electrode operates well on both AC & DC current.

Classification	
AWS	A5.5: E 8018-C2
EN	499: E 46 6 3Ni B 32
EN ISO	2560-A: E 46 6 3Ni B 32

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.05	0.60	0.20	≤ 0.020	≤ 0.015	-	3.30	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 105°C	Hardness
PWHT 620 °C x 1 h	≥ 450	≥ 540	≥ 25	≥ 60	-
As Welded	≥ 450	≥ 540	≥ 25	≥ 40	-

Materials

12Ni14

A352LC3; ASTM A203 D,E ; A300 D,E ; A333 Gr 3 ; A 334 Gr 3

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

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	21,8	13,0
3,2	350	90-130	35,7	21,4
4,0	350	140-170	53,9	32,4
5,0	450	170-210	98,1	58,9