

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

Basic coated electrode for welding of 0,5 % - 2 % nickel steels for use at low temperatures. Excellent mechanical properties of the weld metal in both the as welded and stress relieved conditions. CTOD tested. Vacuum packaging.

Classification	
AWS	A5.5: E8018-C1
EN	499: E 46 6 2Ni B 42
EN ISO	2560-A: E 46 6 2Ni B 42

Approvals	Grades
ABS	
BV	
DNV	
LRS	

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
0.05	1	0.40	≤ 0.020	≤ 0.015	-	2.50	-	-	-	-	-

### 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) - 60 °C	Hardness
As Welded	≥ 460	530-680	≥ 22	≥ 110	-

### Materials

12Ni14, S275-S460, P275-P460

A333 Gr 7, A203 Gr A,B.

### Storage and redrying

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 400-420 °C for 2 hours, once only.

HD ≤ 10: Re-dry at 340-360 °C for 2 hours, 5 times max

### Current condition and welding position

DC+



### Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	350	60-90	20,3	12,2
3,2	350	90-130	33,0	20,0
3,2	450	90-130	40,7	24,4
4,0	450	140-210	64,9	38,8
5,0	450	200-240	99,7	59,8