

MMA Electrodes C-Mn and low-alloy steels

Basic coated electrode producing tough and crack-free welded joints. Weld deposit is of extremely high metallurgical purity and very low hydrogen content. Due to its double coating (up to 3,2 mm), the electrode features a stable and concentrated arc, making it well-suited for positional welding. Welds are of X-ray quality.

Classification	
AWS	A5.5: E8018-C1-H4
EN	499: E 46 6 2 Ni B 42 H5
EN ISO	2560-A: E 46 6 2Ni B 42 H5

Approvals	Grades
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
0.05	1.10	0.30	≤ 0.020	≤ 0.015	-	2.40	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 60 °C	Hardness
PWHT 580 C° x 15 h	≥ 420	520-640	≥ 20	≥ 80	-
As Welded	≥ 480	550-700	≥ 22	≥ 110	-

Materials

12Ni14, S(P)275-S(P)460

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+



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	350	65-95	18,9	12,8
3,2	350	90-130	34,3	22,2
4,0	450	140-185	66,6	45,2
5,0	450	180-240	107,1	70,0