

MMA Electrodes High-strength steels

Basic coated electrode producing tough and crack-free welded joints. Weld deposit is of extremely high metallurgical purity and very low hydrogen content. Welds are of X-ray quality.

Classification	
AWS	A5.5: E8018-G-H4
EN	2560-A: E 50 6 Mn1Ni B 42 H5
EN	499: E 50 6 Mn1 Ni B 42 H 5

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
0.06	1.60	0.50	≤ 0.020	≤ 0.015	-	0.90	-	-	-	-	-

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
As Welded	≥ 510	590-680	≥ 24	≥ 80	-

Materials

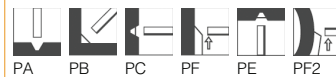
S(P)420-S(P)500; L245-L485

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+



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	350	65-95	23,9	14,0
3,2	350	90-135	35,5	21,0
4,0	450	140-180	68,0	41,0
5,0	450	190-240	108,9	65,0