

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. Due to its double coating (up to 3,2 mm), this electrode features a stable and concentrated arc, making it well-suited for positional welding. Welds are of X-ray quality. On request, electrodes may be supplied with special quality assurance to KTA 1408.2.

Classification

AWS	A5.5: E9018-G-H4
EN	757: E 55 6 Mn1NiMo B T 42 H5

Approvals

ABS
DB
TÜV

Grades

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	1.40	0.30	≤ 0.012	≤ 0.008	-	0.95	0.40	-	≤ 0.05	-	≤ 0.10

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 605 C° x 40 h	≥ 500	630-700	≥ 20	≥ 50	-
As Welded	≥ 560	630-750	≥ 20	≥ 75	-

Materials

A508 Cl.2, A533 Cl.1Gr. B, 13MnNiMo5-4, 17MnMoV6-4; L245-L555
S(P)355-S(P)555, 20MnMoNi5-5, 15NiCuMoNb5, 22NiMoCr3-7

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	20,3	12,3
3,2	350	90-140	34,3	22,7
4,0	450	140-185	68,7	42,7
5,0	450	180-240	111,7	71,5