

MMA Electrodes High-strength steels

Basic coated electrode for welding high yield strength steels (>600N/mm²) when good impact toughness at low temperatures is required.

Classification	
AWS	A5.5: E10018-D2
EN	757: E 62 4 MnMo B32 H5

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.09	1.90	0.50	0.025	0.020	-	-	0.40	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 40 °C	Hardness
As Welded	≥ 620	690-890	≥ 22	≥ 50	-

Materials

S(P)500

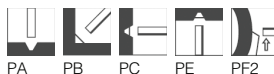
Storage and redrying

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	20,3	12,2
3,2	350	100-130	35,8	21,5
4,0	450	140-190	69,0	41,4