

MMA Electrodes High-strength steels

All-positional low-hydrogen electrode with an efficiency of 110-120% for welding high strength steels having tensile properties of 760-870 N/mm² e.g. T1, HY 80, etc. Use shortest possible arc and low travel speed. The low hydrogen weld metal minimises the risk of cold cracking. Low heat input is recommended. Efficiency 120%.

Classification	
AWS	A5.5: E 11018-M H4
EN	757: E 69 5 Z B 32 H5
GOST	9467-75:Э70-06ГН2-6

Approvals	Grades
ABS	
DNV	

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	0.30	≤ 0.020	≤ 0.020	-	2	0.30	-	-	-	-

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	≥ 690	760-960	≥ 20	≥ 70	-

Materials

T1; HY80; S(P)690

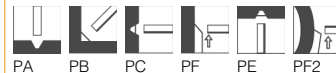
Storage and redrying

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 400-420 °C for 1 hours, 3 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	300	55-105	16,6	10,1
3,2	350	90-140	34,3	22,2
4,0	350	110-180	52,7	32,4
5,0	450	170-240	108,1	66,0