

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), 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: E11018-G-H4
EN	757: E 69 6 Mn2NiCrMo B 42 H5

Approvals	Grades
ABS	
GL	
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	1.40	0.50	≤ 0.020	≤ 0.012	0.40	2.20	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) - 60 °C	Hardness
PWHT 580 C° x 15 h	≥ 650	700-850	≥ 17	≥ 47	-
As Welded	≥ 720	760-900	≥ 17	≥ 60	-

Materials

S(P)690

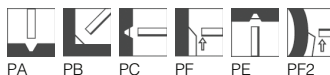
Storage and redrying

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	19,8	12,8
3,2	350	90-140	34,3	22,2
4,0	450	140-185	70,3	45,2
5,0	450	180-240	109,9	70,0