

MMA Electrodes High-strength steels

All-positional low-hydrogen electrode with an efficiency of 110-120% for the welding of high strength steels having yield strength up to 850 N/mm². Use shortest possible arc and low travel speed. The low hydrogen weld metal minimise the risk of cold cracking. Low heat input is recommended.

Classification

AWS	A5.5: E 12018 – M
EN	757: E 79 5 Mn2NiCrMo B 32 H5
GOST	9467-75:Э85-08Г2H2-6

Approvals

Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.08	1.70	0.35	≤ 0.015	≤ 0.015	0.45	1.90	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) -51°C	Hardness
PWHT 580°C x 4 h	≥ 700	790-900	≥ 19	≥ 47	-
As Welded	≥ 790	880-1080	≥ 18	≥ 47	-

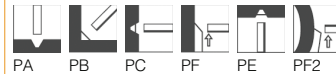
Storage and redrying

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	16,7	10,1
3,2	350	90 - 140	34,3	22,2
4,0	350	110 - 180	51,7	32,4