

## 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: E12018-G-H4
EN	757: E 89 4 Mn2Ni1CrMo B 42 H5

Approvals	Grades
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
0.07	1.70	0.40	-	-	0.80	2.50	0.50	-	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) - 40 °C	Hardness
As Welded	≥ 890	980-1080	≥ 15	≥ 47	-

### Materials

S890

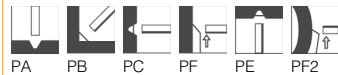
### Storage and redrying

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	20,0	12,9
3,2	350	90-135	34,1	22,0
4,0	450	140-185	69,6	43,0
5,0	450	180-240	110,8	68,0