

MMA Electrodes Nickel and Copper alloys

Basic coated MMA electrode with 140 % recovery for welding steels containing between 5 % and 9 % nickel. To reduce arc blow the special coating also allows welding with AC. Very high resistance to hot cracking and excellent toughness at low temperatures.

Classification

AWS	A5.11: E NiCrMo6
EN ISO	14172: E Ni6620

Approvals

Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.06	3.50	0.20	≤ 0.020	≤ 0.012	13.50	Rem	6	1.30	9.60	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 196 °C	Hardness
As Welded	≥ 430	≥ 690	≥ 35	≥ 75	-

Materials

A 353-70, A 553-70

Steels with 5 - 9 % nickel

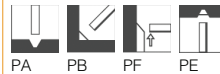
Storage and redrying

Keep dry and avoid condensation.

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	60-80	28,4	17,0
3,2	350	70-90	49,4	29,6
4,0	350	120-140	71,4	42,7
5,0	450	150-180	144,0	86,4