

Rutile thin coated MMA electrode which is easy to use. Weld metal hardness of approx. 240 - 290 HV10 in the as-welded condition. It can reach 400 HV after water-quenching. Designed for surfacing carbon steel rails and track equipment, sideways, shafts, shovel buckets, bridge crane rollers, agricultural and civil works equipment. Deposit a maximum of 3 layers.

Classification	
EN	14700: E Fe1

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.10	-	0.30	-	-	2.40	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	-	-	-	-	240-290

Storage and redrying

Keep dry and avoid condensation.
Re-drying not generally required.
If necessary: 150-200 °C for 2 hours, 5 times max.

Current condition and welding position

AC; DC-



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
3,2	450	90-120	38,3	23,0
4,0	450	120-150	56,8	34,0