TOOLCORD

OERLIKON

MMA Electrodes
Hardfacing

Low hydrogen MMA electrode for hardfacing of high alloy cutting tools, very high temperature resistance, good resistance in wear applications. Weld metal is not machinable. Quenching at 1180-1240°C (oil). Tempering at 510-540°C.
Efficiency 100%.

Classification	
DIN	8555: E 6 UM 65 GS
EN	14700: E Fe4

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
1.50	1	-	-	-	4	-	8	-	Rem	2.50	-

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
Quenched	-	-	-	-	≥ 65 HRC
As Welded	-	-	-	-	≥ 58 HRC

Storage and redrying

Keep dry and avoid condensation.
Re-drying recommended at 300-350 °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	300	60-80	16,6	13,3
3,2	350	90-130	34,3	27,4
4,0	350	125-170	51,3	41,0
5,0	350	190-230	83,5	66,8