



MMA Electrodes C-Mn and low-alloy steels

Basic coated multi-purpose electrode suitable for structural steelwork, workshop and maintenance welding. Smooth and clean welds, blending into the base metal without undercut. Excellent gap bridging properties. The double coating of this electrode produces a stable, concentrated and directed arc, thus being ideally suited for root pass and positional welding. Welds are of X-ray quality.

| Classification | | | | | |
|----------------|-------------------------|--|--|--|--|
| AWS | A5.1:E7016-H8 | | | | |
| EN | 499: E 38 2 B 12 H 10 | | | | |
| EN ISO | 2560-A: E 38 2 B 12 H10 | | | | |

| Approvals | Grades |
|-----------|--------|
| ABS | |
| BV | |
| DB | |
| DNV | |
| GL | |
| LRS | |
| RS | |
| TÜV | |

see Appendix, Classification Society Approvals, for details pag. 521

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

| С | Mn | Si | Р | S | Cr | Ni | Мо | Nb | V | N | Cu |
|------|------|------|---------|---------|----|----|----|----|---|---|----|
| 0.06 | 0.90 | 0.70 | ≤ 0.025 | ≤ 0.015 | - | - | - | - | - | - | - |

All-weld metal Mechanical Properties

| Heat Treatment | Yield Strength N/mm ² | Tensile Strength N/mm ² | Elongation A5 (%) | Impact Energy ISO - V (J) - 20 °C | Hardness |
|----------------|--|--|----------------------|---|----------|
| As Welded | ≥ 380 | 470-600 | ≥ 25 | ≥ 80 | - |

Materials

S(P)235-S(P)355; GP240-GP280; L245-L360

Storage and redrying

Keep dry and avoid condensation. HD \leq 10: Re-dry at 300-350 °C for 2 hours, 5 times max

Current condition and welding position DC+; AC PA PB PC PF PE PE PF PA PB PC PF PE PF2

Packaging data

| Diameter (mm) | Length (mm) | Current (A) | Electrode average weight (g) | Weld metal weight per electrode (g) | | |
|------------------|----------------|----------------|---------------------------------|--|--|--|
| 2,0 | 350 | 55-65 | 12,6 | 7,6 | | |
| 2,5 | 350 | 60-90 | 19,7 | 11,5 | | |
| 3,2 | 350 | 95-150 | 33,0 | 19,8 | | |
| 3,2 | 450 | 95-150 | 42,7 | 26,5 | | |
| 4,0 | 450 | 140-190 | 65,0 | 40,5 | | |
| 5,0 | 450 | 190-250 | 100,5 | 63,0 | | |