

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 %)

C	Mn	Si	P	S	Cr	Ni	Mo	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 ≤ 10: Re-dry 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)
2,0	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