

MMA Electrodes C-Mn and low-alloy steels

CITORAPID 160W is an acid-rutile coated MMA electrode featuring a high burn-off rate and a very high current carrying capacity, suitable for rapid piece-work applications. The solid slag is porous and very easily released even from narrow joints to leave smooth, slightly concave weld beads. Suitable for welding on primer painted and slightly rusted parts. Due to the low silicon content of the weld deposit, applications include parts to be galvanised, enamelled and rubber clad. Weld joints are of X-ray quality.

Classification	
EN ISO	2560-A: E 38 2 RA 73
EN	499: E 38 2 RA 73
AWS	A5.1: E 6027

Approvals	Grade
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si
0.06	0.8	0.25


All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-20 °C
As Welded	≥ 380	470-600	≥ 20	≥ 80	≥ 47

Materials

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

Storage
Keep dry and avoid condensation. Re-drying not generally required. If necessary: 100-110 °C for 1 hour.

Current condition and welding position
AC; DC-

PA PB

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX	
				PC	Code
4.0	450	170-220	97.0	53	●
5.0	450	220-250	153.0	28	●