

MMA Electrodes C-Mn and low-alloy steels

FERROMATIC 180 is a thick rutile coated high-efficiency MMA electrode with a recovery of ~180% and long run-out length. Used for the cost effective filling of thicker weld sections and the welding of long fillet welds. Easy striking and restriking, low spatter, mostly self-releasing slag. The weld bead is very smooth and clean with well blended toes, without undercut into the base plate.

Classification	
EN ISO	2560-A: E 42 0 RR 73
EN	499: E 42 0 RR 73
AWS	A5.1: E 7024

Approvals	Grade
ABS	2
BV	2Y
DB	●
DNV	2
GL	2
LRS	3Ym
RMRS	2
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si
0.1	0.9	0.4

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	0 °C
As Welded	≥ 420	510-610	≥ 22	≥ 60	≥ 47

Materials

S(P)235-S(P)420, 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-; DC+



PA PB

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX	
				PC	Code
4.0	450	160-220	105.2	51	●
5.0	450	225-310	159.0	33	●