

MMA Electrodes C-Mn and low-alloy steels

Thicker rutile coated MMA electrode for welding plates and pipes, FINCORD DB has a slightly thinner coating than FINCORD. Easy weldability, easy striking and restriking and used extensively for tack-welding. Mostly self-releasing slag, leaving a smooth weld bead surface. Welds are of X-ray quality, also in combination with MAG layers.

Classification	
EN ISO	2560-A: E 42 0 RR 1 2
EN	499: E 42 0 RR 1 2
AWS	A5.1: E 6013

Approvals	Grade
DB	●
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si
0.08	0.5	0.35

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-10 °C
As Welded	≥ 420	500-640	≥ 22	≥ 60	≥ 47

Materials

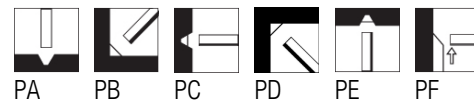
S(P)235 - S(P)355; GP240; GP280

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-



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX	
				PC	Code
2.5	350	60-100	19.4	215	●
3.2	350	95-140	32.9	135	●
4.0	450	130-190	64.3	85	●
5.0	450	170-240	102.5	55	●