

MMA Electrodes C-Mn and low-alloy steels

FINCORD M is a rutile medium coated MMA electrode for a wide variety of mild steel fabrication applications. It has exceptional overall operability and welder appeal, resulting in high quality weld deposits. Excellent in the overhead position and for fillet welding in the horizontal-vertical position. Smooth metal transfer, low spatter and self-releasing slag. Smooth weld bead appearance.

Classification	
EN ISO	2560-A: E 38 0 R 12
EN	499: E 38 0 R 12
AWS	A5.1: E 6013

Approvals	Grade
DB	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.05-0.09	0.3-0.6	0.2-0.5	≤0.02	≤0.02

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation	Impact Energy ISO - V (J)
				0 °C
As Welded	≥ 380	470-600	≥ 22	≥ 50

Materials

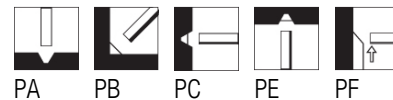
S(P)235 to S(P)355; GP240; GP280

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-; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX	
				PC	Code
2.0	300	40-60	11.0	340	●
2.5	300	45-85	14.6	240	●
2.5	350	55-90	17.2	240	●
3.2	350	80-130	30.5	140	●
4.0	450	120-180	60.0	85	●
5.0	450	160-240	102.7	50	●
6.0	450	220-290	146.7	35	●