

MMA Electrodes C-Mn and low-alloy steels

FINCORD S is a thick rutile coated MMA electrode particularly suited for the welding of horizontal fillets, producing an outstanding fillet shape. Easy striking and restriking with fine droplet metal transfer with a mostly self-releasing slag, producing very smooth welds blending into the base plate without undercut at the toes. Suitable for use with mains transformers. FINCORD also produces an excellent fillet weld shape, but with increased weld metal toughness. For butt welding, FINCORD or FINCORD DB are recommended.

Classification	
EN ISO	2560-A: E 42 A RR 12
EN	499: E 42 A RR 12
AWS	A5.1: E 6013

Approvals	Grade
DB	●
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si
0.08	0.6	0.5

All-weld metal Mechanical Properties

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

Materials

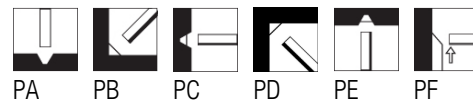
S(P)235 - S(P)355; GP240; GP280

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)	CBOH		CBOX	
				PC	Code	PC	Code
2.0	300	50-70	11.7	150	●		
2.5	350	65-90	21.0			210	●
3.2	350	100-140	35.9			115	●
3.2	450	100-140	47.0			115	●
4.0	450	140-180	69.8			85	●
5.0	450	190-240	107.8			45	●