

MMA Electrodes C-Mn and low-alloy steels

SPEZIAL is a basic, double-coated multi-purpose MMA electrode. The composition of the double coating confers exceptionally good welding characteristics and a highly stable and directional arc. Very good gap bridging and ideally suited for root passes and positional welding. The glassy slag is easily removed from the finely-rippled weld seams, the excellent welding characteristics and ISO-V toughness to -30°C have made SPEZIAL a renowned and reliable electrode for welding structural steelwork, production and assembly jobs in industry and for pipeline construction for decades. Welds are of X-ray quality. Optimum AC weldability requires an OCV > 65V.

Classification

EN ISO	2560-A: E 38 3 B 12 H10
AWS	A5.1: E 7016-H8

Approvals

Approvals	Grade
ABS	3H10-3Y (P)
BV	3-3YHH
DB	●
DNV	3Y40 H10

Approvals

Approvals	Grade
GL	3Y H10
LRS	3m 3Ym H10
RMRS	3YHH
TÜV	●



Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.06	0.9	0.7	≤ 0.020	≤ 0.015

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-30 °C
As Welded	≥ 380	470-600	≥ 25	≥ 150	≥ 60

Materials

S(P)235-S(P)355; GP240-GP280; L245-L360

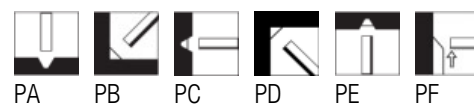
Storage

Keep dry and avoid condensation.

HD ≤ 10: Re-dry at 300-350 °C for 2 hours, 5 times max

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX		VPMD	
				PC	Code	PC	Code
2.0	350	55-65	12.6	330	●	160	●
2.5	350	60-90	19.7	200	●	100	●
3.2	350	95-150	33.0	125	●	55	●
3.2	450	95-150	42.7	125	●	55	●
4.0	450	140-190	65.0	80	●	40	●
5.0	450	190-250	100.4	50	●	25	●