

## RAPID

Electrodes MMA [SMAW]

Construction, unalloyed steels

<b>CLASSIFICATION:</b>	<b>APPROVALS:</b>	<b>APPLICATION:</b>
EN ISO 2560-A : E 38 2 RA 12 DIN 1913 : E 43 33 AR 7 AWS A-5.1 : E 6020	UDT	Constructions & Engineering Mining Light construction and hobby

- Thick coated higher efficiency electrode for welding steel with a tensile strength of up to 600 MPa.
- High speed and deep penetration during the welding in butt and fillet position - especially PA and PB.
- Low spatter, high penetration in the fillet weld positions.
- Resistant to very high current loads during welding and gouging.
- Excellent for welding in tight positions due to very good slag release.
- Recommended for making the filling and top layer when welding steel in the 18G2A grade.
- High-performance welding at high amperages.

### Application

Tanks, boilers, pipelines, steel structures

### Base material

	EN
Construction steels:	S235-S275
Boiler plates:	P235-P275
Pipe steels:	P235-P295
Shipbuilding plates:	A, B, D

### Typical chemical composition %

C	Si	Mn
0,08	0,20	0,60

### Typical mechanical properties

<b>Yield strength Re [N/mm<sup>2</sup>]</b>	>380
<b>Tensile strength Rm [N/mm<sup>2</sup>]</b>	470-600
<b>Elongation A5 [%]</b>	>20
<b>Impact energy Kv [J]</b>	>47J (-20°C) /
<b>Coating type</b>	rutile-acid
<b>Welding current</b>	
<b>Welding positions</b>	
<b>Redrying</b>	140°C / 1h

### Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,5	350 /	70-90	4,4	13,2	48

3,2	450 /	90-160	6,0	18,0	22
4,0	450 /	140-200	5,5	16,5	15
5,0	450 /	180-250	5,4	16,2	9

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