

MMA Electrodes C-Mn and low-alloy steels

FINCORD is a thick rutile coated multi-purpose MMA electrode with outstanding welding characteristics. Exceptionally easy operability makes it suitable for use by lower skilled welders. Easy striking and restriking and used for touch-welding, the arc is stable with very low spatter and the slag is generally self-releasing. The weld beads are finely-rippled and clean, blending into the base plate without undercut. Increased current-carrying capacity of the larger diameters >3.2mm. Suitable for use with mains transformers. For X-ray quality welds in combination with MAG filler layers, Fincord DB is recommended. In horizontal fillet welds, FINCORD S produces an excellent weld bead shape.

Classification	
EN ISO	2560-A: E 42 0 RR 12
EN	499: E 42 0 RR 12
AWS	A5.1: E 6013

Approvals	Grade
ABS	2 (P)
BV	2
DB	●
DNV	2
GL	2Y
LRS	2m
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si
0.08	0.6	0.45

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	0 °C
As Welded	≥ 420	500-640	≥ 22	≥ 60	≥ 47

Materials

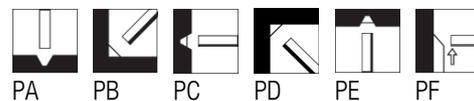
S(P)235 - S(P)355; GP240; GP280

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-



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Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOH		CBOX	
				PC	Code	PC	Code
1.6	250	30-60	5.9	220	●		
2.0	250	50-70	8.9	170	●		
2.0	350	50-70	12.8			340	●
2.5	350	65-90	20.1			210	●
3.2	350	100-140	34.5			125	●
3.2	450	100-150	44.4			125	●
4.0	350	140-210	50.3			80	●
4.0	450	140-210	66.0			80	●
5.0	450	190-280	102.8			50	●
6.0	450	240-320	146.3			33	●