Maxeta 20

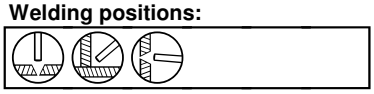
SMAW - (Stick) - MMA

Un-alloyed

Date: 2013-05-30
Revision: 22

Description:
Maxeta 20 is a basic-rutile low hydrogen iron powder electrode with 150% recovery intended for welding of heavier section construction steels. The electrode is particularly suitable for welding of standing fillets enabling the user to make extended run lengths and thereby achieve small fillet welds at high deposition rates. Excellent mitre profile fillets are produced having a smooth transition with the base material. The electrode runs with a stable arc leaving a finely rippled bead surface with self-detaching slag and minimum spatter. It operates equally well on primer-treated material without porosity or fusion line problems along the top edge.

Welding positions:



Coating type:
Basic-rutile

Welding current:
DC+/-, AC OCV> 65 V

Hydrogen content / 100 g weld metal
≤ 10 ml

Metal recovery:
150%

Redrying temperature:
300 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,2	0,9				
Typical	0,05	0,4	1,2	0,010	0,010		
Max	0,10	0,6	1,50	0,030	0,025	0,1	0,1

	Mo	Cu	V	Nb
Min				
Typical				
Max	0,1	0,1	0,05	0,05

Mechanical properties

	Specified	Typical
Yield strength, Re:	≥ 420 MPa	480 MPa
Tensile Strength, Rm:	510-640 MPa	550 MPa
Elongation, A5	≥ 22%	27%
Impact energy, CV:	-20 °C • ≥47 J	-20 °C • 90 J

Classification:

EN ISO 2560-A	E 42 2 RB 53 H10
AWS A5.1	E 7028

Approvals:

CE	
DNV	3YH10
LR	3m, 3Ym, H10

Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
3,2	450	72083200	140-170	29	0,60	24	1,6	85
4,0	450	72084000	180-220	30	0,62	18	2,1	102
5,0	450	72085000	250-320	32	0,64	11	3,6	90