

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.

Structural steelwork, production and assembly jobs in industry and for pipeline construction for decades. Very good gap bridging and ideally suited for root passes. Material to be welded S(P)235; S(P)355; GP 240; GP 280; L 245; L260.

ISO-V toughness at -30°C. Deposit free from porosity and good of X-ray quality. Optimum AC weldability requires an OCV > 65V. Very good gap bridging and ideally suited for root passes and positional welding. The glassy slag is easily removed from the finely-rippled.

Classification

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

Approvals

Approvals	Grade
ABS	3YH10
BV	3YH10
DB	●
DNV	3Y40H10

Approvals

Approvals	Grade
GL	3YH10
LRS	3YmH15
RMRS	3YHH
TÜV	●

CE

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

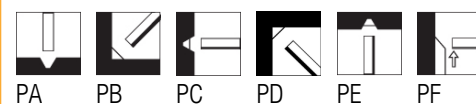
Storage

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. weightn(kg/1000)	CBOX		VPMD	
				PC	Code	PC	Code
2.0	350	55-65	12.73	330	W000287401	160	W000287407
2.5	350	55-95	19.50	200	W000287402	100	W000287408
3.2	350	80-150	32.73	125	W000287403	55	W000287409
3.2	450	95-150	41.82	125	W000287404	55	W000287410
4.0	450	120-190	65.00	80	W000287405	40	W000287411
5.0	450	190-250	100.45	50	W000287406		