Maxeta 10

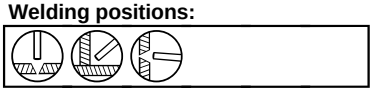
SMAW - (Stick) - MMA

Un-alloyed

Date: 2007-10-19
Revision: 21

Description:
Maxeta 10 is rutile-coated iron powder electrode with 135% recovery intended for welding medium thick sections in general construction steels. The electrode design has been optimised to produce
fillet welds with a good mitre profile and throat thickness in the 3.5-4.0 mm range. Maxeta 10 produces a finely rippled bead surface, minimum spatter and a self-detaching slag.

Welding positions:



Coating type:
Rutile
Welding current:
DC +/-, AC OCV ≥ 65 V

Metal recovery:
135%
Redrying temperature:
90 °C, 2h
Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,40	0,40				
Typical	0,07	0,7	0,6	0,02	0,01		
Max	0,10	0,80	0,80	0,030	0,020	0,1	0,2

	Mo	Cu	V	Nb
Min				
Typical				
Max	0,1	0,2	0,05	0,05

Mechanical properties

	Specified	Typical
Yield strength, Re:	≥420 MPa	470 MPa
Tensile Strength, Rm:	510-610 MPa	570 MPa
Elongation, A5	≥ 22%	24%
Impact energy, CV:	0 °C • ≥47 J	0 °C • 50 J

Classification:

EN 499	E 42 0 RR 53
EN ISO 2560-A	E 42 0 RR 53
AWS A5.1	E 7024

Approvals:

GL	2Y
CE	
ABS	2
BV	2, 2Y
DNV	2
LR	2m, 2Ym

Product 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.)
2,5	350	72022500	90-125	28	0,7	45	1,6	46
3,2	450	72023200	130-160	39	0,73	23	2,2	61
4,0	450	72024000	140-220	30	0,65	17	2,6	73
4,5	600	72024560						
5,0	450	72025000	190-310	31	0,66	11	3,7	78