Maxeta 11

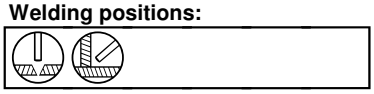
SMAW - (Stick) - MMA

Un-alloyed

Date: 2013-05-30
Revision: 19

Description:
Maxeta 11 is a rutile-coated iron powder electrode with 190% recovery designed for high productivity welding in heavier section mild steel. The electrode is particularly suitable for high speed fillet welding in the downhand and horizontal-vertical positions as well as downhand butt welds. Excellent mitre profile fillets are produced having a smooth transition with the base material. The electrode runs with a smooth stable arc leaving a finely rippled bead surface with self-detaching slag and minimum spatter. It operates equally well on primer-treated material. Maxeta 11 is specially designed to give very low fume emission.

Welding positions:



Coating type:
Rutile
Welding current:
AC OCV> 50V, DC+/-

Metal recovery:
190%
Redrying temperature:
90 °C, 2h
Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,40	0,70				
Typical	0,08	0,6	0,9	0,015	0,01		
Max	0,10	0,80	1,15	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	500 MPa
Tensile Strength, Rm:	510-610 MPa	580 MPa
Elongation, A5	≥ 22%	24%
Impact energy, CV:	0 °C • ≥47 J	0 °C • 50 J

Classification:

EN ISO 2560-A	E 42 0 RR 73
AWS A5.1	E 7024

Approvals:

CE	
DNV	2
GL	2Y
LR	2m, 2Ym
MRS	2
RINA	E 51 2
BV	2
ABS	2

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	72043200	130-170	28	0,72	20	2,5	67
4,0	450	72044000	150-260	31	0,73	13	3,3	76
4,5	450	72044500	170-335	34	0,73	11	5,3	60
4,5	600	72044560	170-250	30	0,73	8	4,2	101
5,0	450	72045000	200-390	35	0,72	8	6,7	61
5,0	600	72045060	200-300	34	0,72	7	5,3	104
5,0	700	72045070	200-290	33	0,72	5	5,4	119
6,0	450	72046000	300-450	35	0,72	6	7,7	71
6,0	600	72046060	300-390	35	0,73	4	7,2	109

6,0	700	72046070	300-380	35	0,73	4	7,2	121