



Maxeta 16

SMAW - (Stick) - MMA
Un-alloyed

Date: 2007-10-19
Revision: 17

Description:

Maxeta 16 is a rutile-coated iron powder electrode with 160% recovery intended for horizontal and fillet welding of heavier section construction steels. The electrode has been specially designed to achieve the highest possible productivity when depositing fillet welds with a throat thickness in the 3.0-4.0 mm range. Fillet welds can be made in primer-treated material without porosity or fusion problems along the top edge. As with the other high recovery electrodes in Elga's programme, Maxeta 16 has excellent slag detachability and very low fume emission.

Welding positions:



Coating type:

Rutile

Welding current:

DC +/-, AC OCV>50 V

Metal recovery:

160%

Redrying temperature:

90 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,30	0,60				
Typical	0,07	0,5	0,7	0,02	0,01		
Max	0,10	0,70	0,95	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

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥ 420 MPa	470 MPa
Tensile Strength, Rm:	510-610 MPa	560 MPa
Elongation, A5	≥ 22%	24%
Impact energy, CV:	0 °C • ≥ 47 J	0 °C • 50 J

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.)
3,2	450	72053200	130-160	28	0,72	21	2,2	72
4,0	450	72054000	150-235	31	0,71	14	3	78
5,0	450	72055000	200-320	31	0,71	9	4,1	86

Classification:

EN 499	E 42 0 RR 73
EN ISO 2560-A	E 42 0 RR 73
AWS A5.1	E 7024

Approvals:

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