



# Maxeta 5

SMAW - (Stick) - MMA  
Un-alloyed

Date: 2007-10-19  
Revision: 22

## Description:

Maxeta 5 is an acid-rutile iron powder electrode with 160% recovery, intended for the welding of general construction steels in the horizontal and horizontal-vertical positions. The electrode is designed to give a fast burn-off rate enabling the user to make extended run lengths and thereby produce small fillet welds at high deposition rates.

It is particularly recommended for plate where the surface has been treated with primer or contaminated by rust, mill scale, paint etc. Both the weld appearance and transition with the base material are exceptionally smooth and consistent, making Maxeta 5 a suitable choice when demands on fatigue resistance of the joint are high.

## Welding positions:



## Coating type:

Acid-rutile

## Welding current:

DC +/-, AC OCV > 65 V

## Metal recovery:

160%

## Redrying temperature:

90 °C, 2h

## Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,10	0,70				
Typical	0,07	0,2	0,9	0,02	0,01		
Max	0,12	0,40	1,10	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	480 MPa
Tensile Strength, Rm:	510-560 MPa	540 MPa
Elongation, A5	≥ 22%	24%
Impact energy, CV:	-20 °C • ≥ 47 J	-20 °C • 70 J

## Classification:

EN 499	E 42 2 RA 73
EN ISO 2560-A	E 42 2 RA 73
AWS A5.1	E 7027

## Approvals:

GL	3Y
CE	
DNV	3
LR	3m, 3Ym
TÜV	
BV	3, 3Y
DB	Kennblatt Nr. 10.042.06
ABS	3

## Note

72016000, TÜV only

## 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	72013200	110-170	32	0,73	22	1,9	77
4,0	450	72014000	150-240	35	0,71	15	2,9	78
5,0	450	72015000	200-360	37	0,71	9	4,8	75
5,0	700	72015070	200-330	37	0,73	6	5,0	118
6,0	450	72016000	280-440	37	0,71	7	5,5	90