



Maxeta 24

SMAW - (Stick) - MMA
Low-alloyed

Date: 2007-10-19
Revision: 21

Description:

Maxeta 24 is a zircon-basic low hydrogen electrode with 160% recovery, producing a nominal 0.9 % Ni weld metal. It is intended for welding fillets and butt joints in the horizontal-vertical and flat positions, combining high deposition rates with very good fracture toughness at temperatures down to -60 °C. Maxeta 24 has excellent CTOD values and is particularly suitable for offshore construction.

Welding positions:



Coating type:

Zircon-basic

Welding current:

DC +/-, AC OCV ≥ 70 V

Hydrogen content / 100 g weld metal

≤ 5 ml

Metal recovery:

160%

Redrying temperature:

350 °C, 2h

Chemical composition, wt.%

| | C | Si | Mn | P | S | Cr | Ni |
|---------|------|------|------|-------|-------|-----|-----|
| Min | | 0,30 | 0,90 | | | | 0,7 |
| Typical | 0,05 | 0,3 | 1,1 | 0,01 | 0,01 | | 0,8 |
| Max | 0,09 | 0,60 | 1,35 | 0,020 | 0,015 | 0,1 | 1,0 |

| | 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: | ≥ 460 MPa | 510 MPa |
| Tensile Strength, Rm: | 530-650 MPa | 600 MPa |
| Elongation, A5 | ≥ 22% | 25% |
| Impact energy, CV: | -50°C • ≥47 J | -50°C • 70 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.) |
|---------|-----------|--------------|-----------|-----------|-----------------------------|---------------------------------|-----------------------------|--------------------------------|
| 4,0 | 450 | 72094000 | 170-240 | 29 | 0,74 | 14 | 3,0 | 80 |
| 5,0 | 450 | 72095000 | 225-355 | 33 | 0,71 | 10 | 4,6 | 78 |

Classification:

| | |
|---------------|--------------------|
| EN 499 | E 46 5 1Ni B 53 H5 |
| EN ISO 2560-A | E 46 5 1Ni B 53 H5 |
| AWS A5.5 | ~E7018-G |

Approvals:

| | |
|-----|----------|
| CE | |
| DNV | 4Y42 H5 |
| ABS | 4Y40 H5 |
| LR | 4Y40m H5 |

Note

CTOD -10°C > 0.25 mm (t: 90 mm, 2G)
AWS: No designation for high recovery.

Approvals are valid for dim.< 5.0 mm.

Core wire:

S ≤ 0.015%

P ≤ 0.015%

N ≤ 0.008%