Maxeta 22

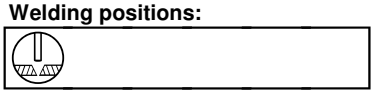
SMAW - (Stick) - MMA

Un-alloyed

Date: 2013-10-21
Revision: 22

Description:
Maxeta 22 is a zircon-basic low hydrogen iron powder electrode with 240% recovery. It is designed for high productivity welding of heavy section mild steel and higher strength steels in the downhand position. Deposition rates with Maxeta 22 are comparable with those for submerged arc welding. The electrode operates on AC/DC but AC is preferable. Maxeta 22 produces a weld metal with very good mechanical properties.

Welding positions:



Coating type:
Zircon-basic

Welding current:
DC+/-, AC OCV> 65 V

Hydrogen content / 100 g weld metal
≤ 10 ml

Metal recovery:
240%

Redrying temperature:
350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,30	0,75				
Typical	0,05	0,5	1,0	0,01	0,01		
Max	0,09	0,70	1,25	0,020	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	PWHT Typical
Yield strength, Re:	≥420 MPa	450 MPa	430 MPa
Tensile Strength, Rm:	510-610 MPa	560 MPa	540 MPa
Elongation, A5	≥22%	26%	
Impact energy, CV:	-20 °C • ≥47J	-20 °C • 110 J	-20 °C • 130 J
	-40 °C • ≥27J	-40 °C • 50J	-40 °C • 70J

Classification:

EN ISO 2560-A	E 42 3 B 74 H10
AWS A5.1	E 7028

Approvals:

CE	
DNV	3Y, H5
GL	3Y H5
LR	3m, 3Ym H5

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.)
4,0	450	72074000	190-240	33	0,74	11,0	4,9	62
5,0	450	72075000	240-360	34	0,76	6,0	8,0	72
5,0	600	72075060	240-340	34	0,75	5,0	7,5	91
6,0	450	72076000	300-470	39	0,75	4,0	10,8	73
6,0	600	72076060	300-450	39	0,75	3,0	10,3	94