

# Manual Metal Arc Electrodes

## General Purpose MMA Electrodes

### Mirrospeed



SFA/AWS A5.1 E6013  
EN ISO 2560-A E 42 0 RR 12

#### Description and applications

Easy-to-weld type electrode for welding in the flat position. The good flowing properties of the weld metal give a good finish of the weld beads both on butt and fillet welds (good slag detachability). The stable arc, also on low welding currents, makes the electrode very suitable for sheet metal welding.

#### All-weld metal properties

Chemical Composition

All weld metal %

	Min	Max
C		0.12
Si	0.35	0.75
Mn	0.25	0.75
P		0.03
S		0.03

#### All-weld metal ISO

As-welded

#### Properties

	Min	Max	
ReL (MPa)	420	460	
Rm (MPa)	510	550	
A5 (%)	25	26	
Charpy V impact values	at 20°C (J)	47	65
	at 0°C (J)	47	

Comments: Elongation = A5

#### Current range

AC (min OCV 40) or DC + (-) -

Size (mm)

2.5 3.2

Current (amps)

50-110 80-140