ETC PH23 FERROMATIC 180



MMA Electrodes C-Mn and low-alloy steels

FERROMATIC 180 is a thick rutile coated high-efficiency MMA electrode with a recovery of \sim 180% and long run-out length. Used for the cost effective filling of thicker weld sections and the welding of long fillet welds. Easy striking and restriking, low spatter, mostly self-releasing slag. The weld bead is very smooth and clean with well blended toes, without undercut into the base plate.

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

Approvals	Grade
ABS	2
BV	2Y
DB	•
DNV	2
GL	2
LRS	3Ym
RMRS	2
TÜV	•
(E	

Chemical analysis (Typical values in %)

C	Mn	Si
0.1	0.9	0.4

All-weld metal Mechanical Properties

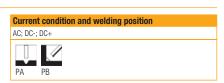
Heat Treatment	Yield Strength	Tensile Strength	Elongation	Impact Energ	gy ISO - V (J)
neat Heatillellt	(MPa)	(MPa)	A5 (%)	+20 °C	0 °C
As Welded	≥ 420	510-610	≥ 22	≥ 60	≥ 47

Materials

S(P)235-S(P)420, GP240-GP280

Storage

Keep dry and avoid condensation. Re-drying not generally required. If necessary: 100-110 $^{\circ}\text{C}$ for 1 hour.



Packaging data

Diam.	Length	Current	Approx. weight	BOX	
(mm)	(mm)	(A)	(kg/1000)	PC	Code
4.0	450	160-220	105.2	51	ETC PH2340
5.0	450	225-310	159.0	33	ETC PH2350

