

# ETC PH45 SUPERCORD 45



## MMA Electrodes C-Mn and low-alloy steels

SUPERCORD 45 is a medium-coated rutile MMA electrode, suitable for all positional welding, except vertical down. The arc is stable even on low open circuit voltage. Applications include tack welding and welding on dirty or primed plate. Efficiency 100%.

### Classification

EN ISO	2560-A: E 42 0 R 12
EN	499: E 42 0 R 12
AWS	A5.1: E 6013
GOST	9467-75: ?50-E51 2

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.06-0.1	0.4-0.7	0.2-0.5	≤0.03	≤0.02

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				0 °C
As Welded	≥ 420	500 - 640	≥ 24	≥ 47

### Materials

S(P)235 to S(P)355; GP240; GP280

### Storage

Keep dry and avoid condensation. Re-drying not generally required. If necessary: 100-110 °C for 1 hour.

### Current condition and welding position

AC; DC-



### Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	BOX	
				PC	Code
1.6	250	20-50	5.7	600	ETC PH4516
2.0	300	40-70	10.8	360	ETC PH4520
2.5	300	60-90	17.7	215	-
3.2	450	90-130	43.8	130	-

