

ETC PH77 SUPERCITO



MMA Electrodes C-Mn and low-alloy steels

SUPERCITO is a heavy basic coated MMA electrode, designed for highly restrained work with static and dynamic loadings. Used in structural engineering, boilers, tanks and vehicle construction and also bridge building and shipbuilding. Recommended for service temperatures down to -50°C. Good CTOD at -10°C.

Classification

EN ISO	2560-A: E 42 5 B 3 2 H5
AWS	A5.1: E 7018-1-H4

Approvals

Approvals	Grade
ABS	3YH5
BV	3YHHH
DB	●
DNV	3YH5

Approvals

Approvals	Grade
GL	3YH5
LRS	3YmH5
RMRS	3YHH
TÜV	●



Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.05-0.08	1.0-1.5	≤0.55	≤ 0.020	≤ 0.020

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-50 °C
As Welded	≥ 430	≥ 510	≥ 24	≥ 47

Materials

S(P)235-S(P)420; GP240-GP280; L245-L360

Storage

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 340-360 °C for 2 hours, 5 times max.

HD ≤ 10: Re-dry at 300-350 °C for 2 hours, 5 times max

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	BOX	
				PC	Code
2.5	350	65-90	22.3	185	ETC PH7725
3.2	350	100-140	35.2	120	ETC PH7732
3.2	450	100-140	46.0	120	-
4.0	450	140-190	68.0	85	ETC PH7740
5.0	450	190-250	100.5	55	ETC PH7750

