



Maxeta 21

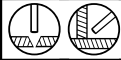
SMAW - (Stick) - MMA
Un-alloyed

Date: 2007-10-19
Revision: 22

Description:

Maxeta 21 is a zircon-basic low hydrogen iron powder electrode with 170% recovery, intended for welding heavier sections in construction and ship steels. It is designed for fast and easy welding in the horizontal position and operates well on both AC and DC. Maxeta 21 can be used on primer-treated material without porosity or other problems and gives good mechanical properties.

Welding positions:



Coating type:

Zircon-basic

Welding current:

DC +/-, AC OCV > 70 V

Hydrogen content / 100 g weld metal

≤ 5 ml

Metal recovery:

170%

Redrying temperature:

350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,20	1,1				
Typical	0,06	0,4	1,25	0,01	0,01		
Max	0,09	0,60	1,4	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

	<u>Specified</u>	<u>Typical</u>	<u>PWHT Typical</u>
Yield strength, Re:	≥ 420 MPa	460 MPa	430 MPa
Tensile Strength, Rm:	500-610 MPa	560 MPa	530 MPa
Elongation, A5	≥ 22%	24%	30%
Impact energy, CV:	-40 °C • ≥47J	-20 °C • 150 J -40 °C • 70 J	-20 °C • 160 J -40 °C • 110J

Product 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	72064000	170-240	30	0,72	14	3,0	80
5,0	450	72065000	225-355	33	0,71	9	4,6	78

Classification:

EN 499	E 42 4 B 73 H5
EN ISO 2560-A	E 42 4 B 73 H5
AWS A5.1	E 7028

Approvals:

CE	
LR	3m, 3Ym, H5
DNV	3YH5
GL	3Y H10

Note

PWHT 600 C 2 h