SUPERBAZ

MMA Electrodes

C-Mn and low-alloy steels

SAF-FRO

SUPERBAZ is thick coated basic MMA electrode, with a stable arc and very low spatter, the slag is easy to remove. It deposits low hydrogen weld metal for service temperatures down to -40°C.
SUPERBAZ is used for welding highly strained components with both static and dynamic loading. Structural engineering applications include, boilers, tanks, chemical industry, pipes fabrication, vehicle construction, bridges and shipbuilding. The weld metal diffusible hydrogen content conforms to low hydrogen, < 5 ml/100g deposited weld metal. Material to be welded:
*OL 44.4; OL 52.2; OL 52.4; OL 50 - STAS 500/2- K 41 .6a; K47.6a - STAS 2883/3 -
*OT 450.1; OT 450.2; OT 450.3; OT 500.1 ; OT 500.2; OT 500.3 - STAS 600 -
*A32; D32; D36 - STAS 8324 -- OCS 44.4a; OCS 52.5a - STAS 9021 -
*EN 10025-2 S(P)235; S(P)355;GP 240; GP 280;L 245;L260. - EN 10028-2 -
*S275; S355; S420 - EN 10113-3
Hydrogen <5mlH2/100g deposited weld metal. Impact toughness down to - 40 °C. Weld metal recovery:~120%. DC and AC, welding current.

Classification	
EN ISO	2560-A: E 42 4 B 42 H5
AWS	A5.1: E 7018 H4

Approvals						
ABS	BV	DB	DNV	GL	LRS	TÜV
3YH5	3YH5	●	3YH5	3YH5	3YH5	●

CE

Chemical analysis (Typical values in %)

	C	Mn	Si	P	S
All weld metal	0.08	1.1	0.45	≤0.025	≤0.015

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Elongation A5 (%)	Impact Energy ISO - V (J) -40 °C
600°Cx1h	≥ 420	500-600	≥ 22	≥ 70
As Welded	≥ 430	510-610	≥ 24	≥ 70

Materials

S185, S235, S275, S355 P235, P265, P295, P335; S275; S355; S420

Storage

Keep dry and avoid condensation.

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

Current condition and welding position

DC-; DC+

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	CBOX	
				PC	Code
2.5	350	65-90	22.22	180	W000288306
3.2	350	120-140	35.71	112	W000288307
3.2	450	120-140	47.01	117	W000288308
4.0	350	160-190	50.63	79	W000288309
4.0	450	160-190	67.90	81	W000288310
5.0	450	210-230	100.90	55	W000288311
6.0	450	210-230	136.36	44	W000288312