

Guide to EN ISO 2560-A: MMA electrodes for non-alloyed and fine grain steels



Symbol	Tensile strength (MPa)	Minimum yield strength (MPa)	Minimum elongation (%)
35	440 to 570	355	22
38	470 to 600	380	20
42	500 to 640	420	20
46	530 to 680	460	20
50	560 to 720	500	18

Symbol	Impact energy Charpy-V at 47 J (°C)
Z	no requirements
A	+20
0	0
2	-20
3	-30
4	-40
5	-50
6	-60

Symbol	Coating type
A	Acid
B	Basic
C	Cellulosic
R	Rutile
RR	Rutile (thick coated)
RC	Rutile-Cellulosic
RA	Rutile-Acid
RB	Rutile-Basic

Covered electrode for manual metal arc welding

E 42 5 B 42 H5

Symbol	Metal recovery (%)	Current type
1	≤ 105	AC and DC
2		DC
3	> 105 ≤ 125	AC and DC
4		DC
5	> 125 ≤ 160	AC and DC
6		DC
7	> 160	AC and DC
8		DC

Symbol	Welding position
1	PA, PB, PC, PD, PE, PF, PG (all positions)
2	PA, PB, PC, PD, PE, PF (all positions, except vertical-down)
3	PA, PB (flat butt weld, flat fillet weld, horizontal-vertical weld)
4	PA (flat butt weld, flat fillet weld)
5	PA, PB, PG (vertical-down and positions according to symbol 3)

Symbol	Max. hydrogen content in weld metal (ml/100g)
H5	5
H10	10
H15	15