

Electrode MR-3



Type E46

Electrodes brand MR-3 are intended for manual arc welding of structural carbon steel with carbon to 0.25%. Welding in all-dimensional position than vertical top-down, direct current reverse polarity and variable currents of power supply with a voltage idling (50 ± 5) B.

The recommended value of current (A)

Diameter, mm	seam position		
	lower	vertical	ceiling
2,5	70-90	60-100	60-100
3,0	90-140	80-100	80-100
4,0	160-220	140-180	140-180
5,0	170-260	160-200	-

Melting electrodes

- Coefficient of surfacing, g / Ah: 8.5
- Depletion of electrodes on 1kgs surfaced metal kg: 1.7

The main characteristics of the metal and weld metal surfaced

The mechanical properties of metal weld, not less

- Temporary breaking strength, MPa: 460
- Relative elongation, %: 20
- Impact strength, J / cm²: 80

Chemical composition surfaced metal%

- Carbon, no more: 0.12
- Manganese: 0,35-0,70
- Silicon: 0,09-0,25
- Sulfur, no more: 0,040
- Phosphorus, no more: 0,045

GOST 9466-75
GOST 9467-75
TU 1272-005-01055859-2003

AWS: E6013
EN499: E382RS12

E46-MP-3-Ø-UD / E 431 (3)
RTS23