

SAFER N 49

MMA Electrodes

C-Mn and low-alloy steels



SAFER N 49 is a basic, double-coated multi-purpose MMA electrode. The composition of the double coating confers exceptionally good welding characteristics and a highly stable and directional arc. The glassy slag is easily removed from the finely-rippled weld seams. The excellent welding characteristics and ISO-V toughness to -30°C. Structural steelwork, production and assembly jobs in industry and for pipeline construction for decades. Very good gap bridging and ideally suited for root passes for Maintenance and repair. Material to be welded: EN 10025-2 S(P)235; S(P)355; GP 240; GP 280; L 245; L260.

ISO-V toughness at -30°C. Deposit free from porosity and good of X-ray quality. Optimum AC weldability requires an OCV > 65V. Very good gap bridging and ideally suited for root passes and positional welding. The glassy slag is easily removed from the finely-rippled.

Classification	
EN ISO	2560-A: E 38 3 B 12 H10
AWS	A5.1: E 7016 H8

Approvals	
DB	TÜV
●	●

CE

Chemical analysis (Typical values in %)

	C	Mn	Si	P	S
All weld metal	0.06	0.9	0.7	≤ 0.020	≤ 0.015

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-20 °C
As Welded	≥ 380	470-600	≥ 22	≥ 80

Materials

S(P)235-S(P)355; GP240-GP280; L245-L360

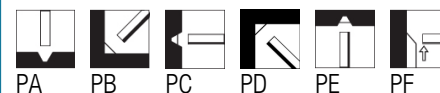
Storage

Keep dry and avoid condensation.

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. weightn(kg/1000)	CBOX	
				PC	Code
2.0	350	55-65	12.73	330	W000380888
2.5	350	50-95	19.5	200	W000288524
3.2	350	80-150	32.73	125	W000288525
3.2	450	95-150	41.82	125	W000288526
4.0	450	120-190	65.0	80	W000288527
5.0	450	190-250	100.45	50	W000288528