

SAFER NF 510P

MMA Electrodes

C-Mn and low-alloy steels



SAFER NF 510P is a basic electrode with a metal recovery of approximately 120%. Smooth and stable arc, low spattering loss and high welding speed.

Ideal on assemblies down to temperatures of -40 °C. High welding speed in Vertical Up. Low moisture content of the coating and low diffusible hydrogen. EN 10025-2 S(P)235; S(P)355; GP 240; GP 280; L 245; L260.

Excellent Mechanical Properties. Deposit free from porosity. Excellent slag detachability in position.

Classification

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

Approvals

ABS	BV	DB	DNV	GL	LRS
3YH5	3YH5	●	3YH5	3YH5	3YmH5



Chemical analysis (Typical values in %)

	C	Mn	Si	P	S
All weld metal	0.07	1.1	0.4	≤ 0.02	≤ 0.02

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Impact Energy ISO - V (J)
				-30 °C
As Welded	≥ 420	≥ 510	≥ 22	≥ 47

Materials

S(P)235-S(P)420; GP240-GP280; L245-L360

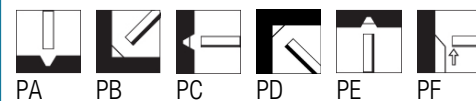
Storage

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 340-360°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
2.5	350	65-90	22.16	185	W000288319
3.2	350	100-140	35.2	120	W000288320
3.2	450	100-140	45.83	120	W000288321
4.0	450	140-190	68.24	85	W000288322
5.0	450	190-250	100.5	55	W000288323
6.0	450	250-270	136.36	44	W000279869