

MMA Electrodes Stainless and Heat resistant steels

Low hydrogen MMA electrode suitable for the welding of 15-17% Cr steels (AISI 430). These steels have been developed for air hardening and pre-heating and stress relieving treatments are required in order to obtain a suitable ductility to allow mechanical working.

Classification	
AWS	A5.4: E 430-15
EN	1600: E 17 B 32 (nearest)
Wr.	1.4016

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.04	0.60	0.40	≤ 0.030	≤ 0.025	16	-	-	-	-	-	-

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	Hardness
PWHT 790°C x 2h	≥ 300	≥ 450	≥ 20	≥ 47	-

Materials

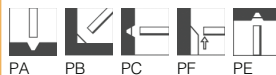
AISI 430

Storage and redrying

Keep dry and avoid condensation.
Re-dry at 280-300 °C for 1 hour, 5 times max

Current condition and welding position

DC+; AC



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
3,2	350	85-140	40,0	24,1
4,0	350	120-190	55,0	33,0