

MMA Electrodes Stainless and Heat resistant steels

Fume reduced, rutile coated MMA electrode for welding austenitic stainless Cr-Ni steels or cast steels. The reduced fume formation contributes to an improved working environment for welders and in workshops. The welding fume deposit in the welding zone and on the work piece is considerably lower than with standard electrodes.

For operating temperatures of up to +350 °C, non-scaling up to +800 °C. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easy slag removal, excellent arc striking and restriking. Vacuum packaging: no redrying or special storage conditions.

Classification	
AWS	A5.4: E 308L-17
EN	1600: E 19 9 L R 22

Approvals	Grades
DB	
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
≤ 0.03	0.80	0.90	≤ 0.025	≤ 0.020	19	10.50	-	-	-	-	5-10

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
As Welded	≥ 350	≥ 520	≥ 30	≥ 50	-

Materials

1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4311 (X2CrNiN18-10)

AISI 304 - 304L - 302

Storage and redrying

Keep dry and avoid condensation.

Re-drying not generally required

If necessary: 250-300 °C for 2 hours, 5 times max

Current condition and welding position

DC+



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	70-80	18,6	11,2
3,2	350	110-120	35,2	21,0
4,0	350	125-135	53,3	32,0