

MMA Electrodes Stainless and Heat resistant steels

Rutile coated MMA electrode for welding austenitic stainless Cr-Ni steels or cast steels, having an extra low carbon content, as well as stainless or heat resisting chromium steels or cast steels. 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, easily removable slag. Easy arc striking and restriking.

Classification

AWS	A-5.4: E308L-17
EN	1600: E19 9 L R 12

Approvals

DB
TÜV

Grades

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	-	-	-	-	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: 300-350 °C for 2 hours, 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)
2,0	300	35-60	11,0	6,6
2,5	300	45-80	17,4	10,4
3,2	350	70-120	35,8	21,5
4,0	350	100-150	53,0	31,8
5,0	450	130-230	107,1	64,2