

## MMA Electrodes Stainless and Heat resistant steels

Semi-basic MMA electrode suitable for welding austenitic stainless steels such as AISI 304 and AISI 304L. A good compromise between bead appearance and ease of use (especially in position, including pipework) and mechanical characteristics. Efficiency 100%.

Classification	
AWS	A5.4: E308L-16
EN	1600: E 19 9 L R 12

Approvals	Grades
ABS	
BV	
DNV	
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
0.025	1.30	0.60	≤ 0.030	≤ 0.030	19.20	10.20	-	-	-	-	4-10

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
As Welded	≥ 320	≥ 520	≥ 35	≥ 80	-

### 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 recommended at 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	30-60	10,7	6,4
2,5	300	50-80	17,1	10,2
3,2	350	60-120	31,2	21,3
4,0	350	100-140	52,9	31,7
5,0	350	130-190	107,1	64,1