

## MMA Electrodes Stainless and Heat resistant steels

Basic coated MMA electrode for welding austenitic stainless Cr-Ni steels or cast steels, having a 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. Well-suited for positional welding. Easy slag release. Vacuum packaging.

Classification	
AWS	A5.4: E308L-15
DIN	8556: E 19 9 L B 20 +
EN	1600: E 19 9 L B 42

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
≤ 0.04	1	0.40	≤ 0.025	≤ 0.025	19	10	-	-	-	-	5-10

### 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	≥ 350	≥ 520	≥ 30	≥ 75	-

### Materials

1.4301 (X4CrNi18-10) - 1.431 (X2CrNi18-10)  
1.4541 (X6CrNiTi18-10)

### Storage and redrying

Keep dry and avoid condensation.  
Re-drying not generally required  
If necessary: 280-300 °C for 1 hour, 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	50-75	17,5	10,5
3,2	350	70-110	32,8	19,7
4,0	350	110-150	49,5	29,7