BASINOX 308LT

OERLIKON

MMA Electrodes
Stainless and Heat resistant steels

Low hydrogen MMA electrode suitable for the welding of austenitic stainless steels. Low carbon content and very good mechanical properties at -196°C. Efficiency 100%.

Classification	
AWS	A5.4: E 308L-15
EN	1600: E 19 9L B 12
GOST	10052-75: Э04Х20Н9

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.025	1.50	0.30	≤ 0.030	≤ 0.030	19	10	-	-	-	-	1-5

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm^2	Tensile Strength N/mm^2	Elongation A5 (%)	Impact Energy ISO - V (J) -196°C	Hardness
As Welded	≥ 320	≥ 520	≥ 35	≥ 47	-

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: 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)
2,5	300	45-70	15,9	9,5
3,2	350	65-120	32,0	19,2
4,0	350	100-140	47,8	28,6