

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

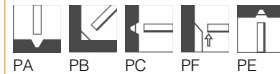
1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4311 (X2CrNiN18-10)
 AISI 304 - 304L - 302

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