

MMA Electrodes Stainless and Heat resistant steels

Low hydrogen MMA electrode suitable for welding of austenitic stainless steels such as AISI 304L. The special coating allows vertical up welding and makes BASINOX 308L-VU particularly suitable for welding on site. The heavily basic coating provides excellent protection of the weld pool from oxidation. Efficiency 100%

Classification	
AWS	A5.4: E308L-15
EN	1600: E 19 9 L 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	1.40	0.40	≤ 0.030	≤ 0.030	19	9	-	-	-	-	3-8

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	≥ 320	≥ 520	≥ 35	≥ 60	-

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	60 - 90	17,4	10,4
3,2	350	80 - 110	31,2	18,9
4,0	350	100 - 130	49,5	29,7