

MMA Electrodes Stainless and Heat resistant steels

Rutile coated MMA electrode for welding stabilized austenitic stainless Cr-Ni steels or cast steels, as well as stainless or heat resisting Cr steels or cast steels. For operating temperatures of up to +400 °C, non-scaling up to +800 °C. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easy slag removal, easy arc striking and restriking.

Classification	
AWS	A5.4: E347-16
EN	1600: E 19 9 Nb R 12

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
≤ 0.03	0.80	0.90	≤ 0.025	≤ 0.020	19	10	-	0.40	-	-	5-10

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	≥ 420	≥ 600	≥ 25	≥ 50	-

Materials

1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4550 (X6CrNiNb18-10);
AISI 347 - 321

Storage and redrying

Keep dry and avoid condensation.
Re-drying not generally required.
If necessary: 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	35-60	10,9	6,5
2,5	300	45-80	17,8	10,7
3,2	350	70-120	35,4	21,2
4,0	350	100-150	53,9	32,3