

MMA Electrodes Stainless and Heat resistant steels

Semi-basic MMA electrode suitable for welding stabilized austenitic stainless steels AISI 321 and AISI 347. The Nb+Ta in the weld metal is due to the Ti sublimation at the liquidus temperature of the weld pool. The weld metal mechanical properties are excellent at high temperatures. Excellent weldability with a spatter free arc, self-releasing slag results in a very smooth bead appearance. Efficiency 100%. Packed in Gaspack system.

Classification	
AWS	A5.4: E 347-16
EN	1600: E 19 9Nb R 12
GOST	10052-75: Э08Х20Н10Г 2Б similar

Approvals	Grades
MMI	
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
0.05	0.80	0.60	≤ 0.025	≤ 0.020	19	10	-	0.50	-	-	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	≥ 350	≥ 550	≥ 30	≥ 48	-

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: 350-370 °C for 1 hour, 3 times max.

Current condition and welding position

AC; DC+



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,0	300	30-60	11,1	6,6
2,5	300	50-80	18,7	11,2
3,2	350	60-120	35,0	21,0
4,0	350	100-140	52,5	31,5
5,0	350	130-180	82,6	49,5