

## MMA Electrodes Stainless and Heat resistant steels

Semi-basic MMA electrode suitable for welding austenitic stainless steels, niobium or titanium stabilized, such as AISI 321 and AISI 347. A good compromise between appearance and ease of use (especially in position including pipework) and mechanical characteristics. Efficiency 100%.

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

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	0.60	≤ 0.030	≤ 0.030	20	10.30	-	0.70	-	-	5-15

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
As Welded	≥ 350	≥ 550	≥ 30	≥ 75	-

### Materials

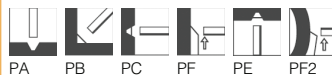
1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4550 (X6CrNiNb18-10);  
AISI 347 - 321

### Storage and redrying

Keep dry and avoid condensation.  
Re-drying recommended at 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)
2,5	300	50-80	17,0	10,2
3,2	350	60-120	33,4	20,0
4,0	350	100-140	47,3	28,4