BASINOX 347

OERLIKON

MMA Electrodes
Stainless and Heat resistant steels

Basic 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. Very good positional welding characteristics. Easy slag release. Vacuum packaging.

Classification	
AWS	A5.4: E347-15
EN	1600: E 19 9 Nb B 42

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
≤ 0.04	1	0.40	≤ 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	≥ 70	-

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: 280-300 °C for 1 hour, 5 times max.

Current condition and welding position

DC+

Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	45-80	17,7	10,6
3,2	350	50-125	33,2	19,9
4,0	350	90-150	48,2	28,9