

MMA Electrodes Stainless and Heat resistant steels

Basic-coated MMA electrode suitable for the welding of dissimilar steels, quenched and tempered steels 13% Mn and Cr steels. BASINOX 307 is also used for difficult to weld steels. Good corrosion and wear resistance. Excellent mechanical properties and high crack resistance. Efficiency 100%

Classification	
AWS	A5.4: E 307-15
EN	1600: E 18 9 MnMo B 12
GOST	10052-75: Э10Х20Н9Г6С

Approvals	Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.08	4	0.50	≤ 0.030	≤ 0.030	19.50	9.50	1	-	-	-	≤ 5

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	≥ 590	≥ 30	≥ 80	-

Materials

Armour plate; Dissimilar Steels
X120Mn12 (1.3401)

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	50-75	18,1	10,8
3,2	350	70-120	34,8	21,0
4,0	350	90-120	49,6	29,7
5,0	350	110-115	75,0	45,0