

## MMA Electrodes Stainless and Heat resistant steels

Semi-basic MMA electrode depositing austenitic-ferritic weld metal which is highly resistant to cracking. Particularly suitable for the welding of dissimilar steels (i.e. stainless steel to mild steel) where heat treatments are applicable, both before and after welding. For hardfacing DW RSP may be used as a buffer layer. Excellent weldability with a spatter free arc, self-releasing slag combined with a very smooth bead appearance. Efficiency 100%. Packed in Gaspack system.

Classification
Not

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.03	0.90	0.80	≤ 0.025	≤ 0.020	19	10	3	-	-	-	5-20

### 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	≥ 580	680 - 780	≥ 26	≥ 60	-

### Materials

Dissimilar joints

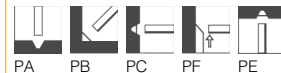
### Storage and redrying

Keep dry and avoid condensation.

If necessary Re-dry at 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	30-50	11,5	6,9
2,5	300	45-75	18,9	10,6
3,2	350	60-120	35,8	19,5
4,0	350	90-140	52,3	28,8
5,0	350	130-180	84,8	50,8