

MMA Electrodes Stainless and Heat resistant steels

Low hydrogen MMA electrode suitable for the welding of stainless steels type AISI 316 and 316L. Excellent mechanical properties of the weld deposit to -196°C. Efficiency 100%.

Classification	
AWS	A5.4: E 316L-15
EN	1600: E 19 12 2 B 12

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.02	1.45	0.30	≤ 0.030	≤ 0.025	17.80	12.50	2.50	-	-	-	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) -196°C	Hardness
As Welded	≥ 350	≥ 550	≥ 35	≥ 47	-

Materials

1.4401 (X4CrNiMo17-12-2), 1.4435 (X2CrNiMo18-14-3)

1.4571 (X6CrNiMoTi17-12-2), 1.4583 (X10CrNiMoNb18-12)

AISI 316L

Storage and redrying

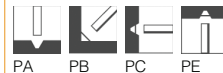
Keep dry and avoid condensation.

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	45-70	16,1	9,6
3,2	350	65-120	31,5	18,9
4,0	350	115-140	48,1	28,8