

MMA Electrodes Stainless and Heat resistant steels

BASINOX 316LN is suitable for the welding of cryogenic austenitic stainless steels and non magnetic stainless steels. The weld metal has an excellent resistance to very aggressive corrosive environments, such as urea. Good impact toughness at -196°C. Efficiency 100%.

Classification	
EN	1600: E 20 16 3 Mn N L
Wr.	1.4455

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.025	7	0.30	≤ 0.020	≤ 0.020	20	16	3	-	-	0.15	-

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	≥ 320	≥ 510	≥ 30	≥ 27	-

Materials

AISI 304LN

AISI 316LN

Storage and redrying

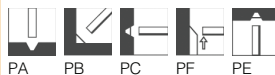
Keep dry and avoid condensation.

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	15,2	10,48
3,2	350	65-120	30,1	19,9
4,0	350	115-140	43,8	28,5