

MMA Electrodes Stainless and Heat resistant steels

Rutile coated MMA electrode for welding stabilized austenitic stainless Cr-Ni-Mo steels and cast steels. For operating temperatures of up to +400 °C. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easy slag removal, easy arc striking and restriking. Vacuum packaging.

Classification	
AWS	A5.4: E318-16
EN	1600: E 19 12 3 Nb R 12

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
≤ 0.03	0.80	0.90	≤ 0.025	≤ 0.020	18.50	12	2.70	-	-	-	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	≥ 350	≥ 550	≥ 30	≥ 50	-

Materials

1.4571 (X6CrNiMoTi17-12-2) - 1.4401 (X4CrNiMo17-12-2)
 1.4580 (X6CrNiMoNb17-12-2) - 1.4408 (GX5CrNiMo19-11)
 1.4581 (GX5CrNiMoNb19-10) - 1.4436 (X4CrNiMo17-13-3)
 1.4583 (X10CrNiMoNb18-12)

Storage and redrying

Keep dry and avoid condensation.
 Re-drying not generally required.
 If necessary: 300-350 °C for 2 hours, 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)
2,0	300	35-60	11,4	6,8
2,5	350	45-80	17,9	10,7
3,2	350	70-120	35,2	21,1