BASINOX 318

OERLIKON

MMA Electrodes
Stainless and Heat resistant steels

Basic coated MMA electrode for welding stabilized austenitic stainless Cr-Ni-Mo steels and cast steels. For operating temperatures of up to +400 °C. Very good positional welding characteristics. Easy slag release. Vacuum packaging.

Classification	
AWS	A 5.4: E318-15
EN	1600: E 19 12 3 Nb B 42

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
≤ 0.04	1	0.40	≤ 0.025	≤ 0.020	19	11.50	2.70	0.40	-	-	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: 280-300 °C for 1 hour, 5 times max.

Current condition and welding position

DC+

Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	45-80	17,4	10,4
3,2	350	50-125	33,6	20,2
4,0	350	90-150	49,1	29,5