

MMA Electrodes Stainless and Heat resistant steels

Low-hydrogen MMA electrode suitable for the welding of austenitic stainless steels containing 22-25% Cr and 12-14% Ni (AISI 309). The weld deposit carbon content is 0.04% max. Suitable for welding of dissimilar steels (i.e. carbon steel to stainless steel) and for buffer layers, cladding. Excellent weldability with a spatter free arc, self-releasing slag combined with a very smooth bead appearance. Good corrosion resistance. Efficiency 100%.

Classification	
AWS	A5.4:E 309L-15
EN	1600: E 23 12 L B 12
GOST	10052-75: Э10Х25Н13Г2 simila

Approvals	Grades
MMI	

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
0.025	1.40	0.35	≤ 0.030	≤ 0.025	22.50	13	-	-	-	-	5-15

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
As Welded	≥ 320	≥ 520	≥ 30	≥ 60	-

Materials

A312 TP309S; carbon steel to stainless steels joint

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	17,4	11,1
3,2	350	65-120	34,5	21,4
4,0	350	115-140	49,6	29,7
5,0	350	130-180	75,0	45,0