

MMA Electrodes Stainless and Heat resistant steels

Low hydrogen MMA electrode suitable for the welding of stainless steels type AISI 309. The Nb content improves the resistance to intergranular corrosion and also the mechanical properties when working at high service temperatures. Used for the welding of buffer layers on AISI 347 clad steels and dissimilar steels. Max service temperature +1000°C. Efficiency 100%.

Classification	
AWS	A5.4: E 309Cb-15
EN	1600: E 23 12 Nb B 12
GOST	10052-75: Э10 25H13Г2 Б

Approvals	Grades
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
0.025	1.50	0.45	≤ 0.030	≤ 0.025	22.50	13	-	0.80	-	-	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	≥ 350	≥ 550	≥ 30	≥ 60	-

Materials

Cladding of carbon steel and low alloy steel

Storage and redrying

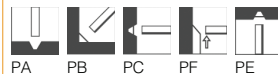
Keep dry and avoid condensation.

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	18,0	11,0
3,2	350	65-120	36,0	21,8
4,0	350	115-140	50,0	30,6
5,0	350	130-180	77,4	46,4