

MMA Electrodes Stainless and Heat resistant steels

Rutile coated MMA electrode suitable for the welding of steels type AISI 309. Also suitable for the welding of dissimilar steels, buffer layers and cladding. Excellent weldability with a spatter free arc, self-releasing slag combined with a very smooth bead appearance. Efficiency 100%. Packed in Gaspack system.

Classification	
AWS	A5.4: E 309Mo-16
EN	1600: E 23 12 2L R 12
GOST	10052-75: Э10Х25Н13Г2 similar

Approvals	Grades
RINA	

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
0.021	0.90	0.80	≤ 0.030	≤ 0.030	22.70	12.70	2.50	-	-	-	9-25

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	≥ 47	-

Materials

Cladding of carbon steel and low alloy steel

Storage and redrying

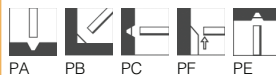
Keep dry and avoid condensation.

Re-drying not generally required

If necessary: 350-370 °C for 1 hour, 3 times max

Current condition and welding position

AC; DC+



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	45-70	19,2	11,9
3,2	350	65-120	37,0	22,0
4,0	350	115-140	55,2	33,1
5,0	350	130-180	87,2	52,3