

MMA Electrodes Stainless and Heat resistant steels

Rutile coated high-efficiency MMA electrode for welding dissimilar steels (ferritic to austenitic steels) and depositing austenitic stainless cladding, having a metal recovery of 160 %. The austenitic weld metal has a delta-ferrite content of approx. 15%. Cladding on unalloyed steels is already corrosion resistant in the first layer. Highest operating temperature for dissimilar steel joints is +300 °C. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easy slag removal, easy arc striking and restriking.

Classification	
AWS	A 5.4: E309Mo-26
EN	1600: E 23 12 2 L R 53

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	1	0.80	≤ 0.025	≤ 0.020	22	12	2.80	-	-	-	12-20

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	≥ 580	≥ 30	≥ 40	-

Materials

Cladding of carbon steel and low alloy steel

Storage and redrying

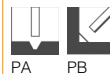
Keep dry and avoid condensation.

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)
2,5	350	70-110	31,9	19,0
3,2	450	110-165	69,5	41,7
4,0	450	170-210	106,1	63,7