

MMA Electrodes Stainless and Heat resistant steels

Low hydrogen MMA electrode suitable for the welding of stainless steels type AISI 309. Particularly suitable for the welding of dissimilar steels (stainless steels to carbon steels). Service temperature up to +1000°C, at elevated temperatures the Mo content improves the creep properties. Efficiency 100%.

Classification	
AWS	A5.4: E 309MoL-15
EN	1600: E 23 12 2L B 12

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.025	1.40	0.40	≤ 0.030	≤ 0.025	22.50	13	2.50	-	-	-	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

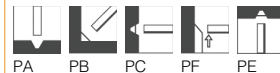
Keep dry and avoid condensation.

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	18,5	11,1
3,2	350	65-120	36,0	22,0
4,0	350	115-140	51,8	31,6
5,0	350	130-180	78,5	46,5