

# BASINOX EB 25.10.4 N

## MMA Electrodes Stainless and Heat resistant steels

Low-hydrogen MMA electrode suitable for the welding of superduplex stainless steel, type UNS32550 – UNS32760; depositing weld metal with a high resistance to pitting and crevice corrosion (PREN > 40). Particularly suitable for pressure vessels, piping and off-shore processing equipment. Packed in Citodry.  
Efficiency 115%.

Classification	
EN	1600: E 25 9 4 N L B 42

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.03	0.90	0.80	≤ 0.030	0.025	25	9.50	4	-	-	0.25	35-70

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) -40°C	Hardness
As Welded	≥ 650	≥ 850	≥ 20	≥ 27	-

### Materials

SAF 2507; Uranus 47N; UNS S32750; ASTM A182 F53

### Storage and redrying

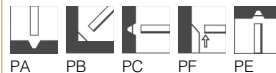
Keep dry and avoid condensation.

Re-drying not generally required.

If necessary: 280-300 °C for 1 hour, 5 times max.

### Current condition and welding position

DC +



### Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
3,2	350	100 – 140	33,3	23,0
4,0	350	130 – 180	49,6	37,0