

MMA Electrodes Stainless and Heat resistant steels

Rutile coated MMA electrode for joining dissimilar steels and depositing cladding on ferritic steels. The ferritic-austenitic Cr-Ni weld metal contains approximately 50% delta-ferrite and is non-scaling up to 1100 °C. It features high resistance to cracking and is therefore suited to joining difficult-to-weld steels and depositing stress-relaxing buffer layers on crack sensitive base metals. Suitable for welding galvanized steel plates. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easy slag removal, easy arc striking and restriking.

Classification	
AWS	A5.4: E312-16
EN	1600: – E 29 9 R 12

Approvals	Grades
DB	

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
0.10	1	1.10	≤ 0.025	≤ 0.020	29	12	-	-	-	-	50

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	≥ 600	≥ 750	≥ 20	-	≥ 220 HB

Materials

Dissimilar and difficult to weld steels

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)
2,0	300	35-60	11,6	7,0
2,5	300	55-85	18,7	11,0
3,2	350	80-120	37,1	22,0
4,0	350	110-150	54,1	32,0
5,0	350	160-220	81,7	49,0