

MMA Electrodes Stainless and Heat resistant steels

Fully austenitic basic coated MMA electrode suitable for welding heat resistant alloys (up to 1150°C) containing 25% Cr and 20% Ni (AISI 310).

Efficiency 100%.

Classification	
AWS	A5.4: E 310-15
EN	1600: E 25 20 B 12

Approvals	Grades
MMI	

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
0.09	2	0.60	≤ 0.030	≤ 0.025	26.50	20.80	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -196°C	Hardness
As Welded	≥ 350	≥ 550	≥ 30	≥ 27	-

Materials

AISI 310; 1.4845 (X8CrNi25-21); 1.4841 (X15CrNiSi25-21); 1.4828 (X15CrNiSi20-12)

Storage and redrying

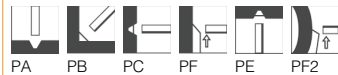
Keep dry and avoid condensation.

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	18,8	11,2
3,2	350	70-120	34,6	20,7
4,0	350	110-140	51,6	30,9
5,0	350	140-170	77,5	46,5