

MMA Electrodes Stainless and Heat resistant steels

Basic coated MMA electrode depositing a fully austenitic weld metal suitable for the welding of heat resisting alloys (up to +1150°C) containing 25% Cr and 20% Ni (AISI 310). Used for rebuilding on AISI 316L clad steels. Efficiency 100%.

Classification

AWS A5.4: E 310Mo-15

Approvals

Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.10	1.50	0.50	≤ 0.030	≤ 0.025	25	20.50	2.80	-	-	-	-

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	≥ 400	≥ 550	≥ 30	≥ 27	-

Materials

AISI 310; cladding

Storage and redrying

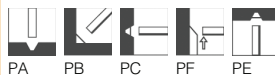
Keep dry and avoid condensation.

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	18,3	10,9
3,2	350	70-120	33,0	19,8
4,0	350	110-140	50,0	30,0