

## MMA Electrodes Stainless and Heat resistant steels

Rutile coated MMA electrode for welding austenitic stainless steels with enhanced corrosion resistance to reducing media. Weld metal consists of austenite without delta-ferrite and exhibits increased resistance to pitting and crevice corrosion in chloride-bearing media.

Classification	
AWS	A5.4: E385-16
EN	1600: E 20 25 5 Cu N L R12

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
≤ 0.03	1.10	0.70	≤ 0.025	≤ 0.020	20.60	24.50	4.20	-	1.30	-	-

### 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) + 20 °C	Hardness
As Welded	≥ 320	≥ 510	≥ 25	≥ 80	-

### Materials

URANUS B6; AISI 904L; 1.4539 (X1NiCrMoCu25-20-5); 1.4439 (X2CrNiMoN17-13-5); 1.4537 (X1CrNiMoCuN25-25-5)

### 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)
2,5	300	45-70	16,5	10,0
3,2	350	70-120	32,6	19,6
4,0	350	110-140	49,6	29,8