

## MMA Electrodes Stainless and Heat resistant steels

Basinox 904L is suitable for the welding of Ni-Cr-Mo stainless steel with a low carbon content. Very good resistance to intergranular and pitting corrosion. It is particularly suitable for URANUS B6 - NSCD - HU7 - HU9, AISI 904L. Efficiency 150%.

Classification	
AWS	A5.4: E 385-15
EN	1600: E Z 20 25 5 CuL B 12

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.027	1.70	0.50	≤ 0.030	≤ 0.025	21	24.60	4.80	-	1.50	-	-

### 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	≥ 310	≥ 520	≥ 30	≥ 47	-

### 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: 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	65-80	25,8	15,4
3,2	350	95-120	50,1	30,0
4,0	350	130-160	72,6	46,0
5,0	350	165-200	112,5	54,1