

MMA Electrodes Stainless and Heat resistant steels

Basic coated MMA electrode for welding type AISI 304H or Wr. 1.4948 steels. Developed for high temperature applications (petrochemical and nuclear industry).

Efficiency 100%. Packed in Gaspack system.

Classification	
AWS	A5.4: E308H
EN	1600: E 19 9 H B 42

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.05	1	0.40	≤ 0.025	≤ 0.025	19	10	-	-	-	-	3-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
As Welded	≥ 350	≥ 550	≥ 35	≥ 47	-

Materials

AISI 304H; 1.4948 (X6CrNi18-10); 1.4310 (X10CrNi18-8)

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+



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,0	300	30-55	10,0	6,0
2,5	300	45-70	17,5	10,0
3,2	350	65-120	32,8	19,4
4,0	350	100-140	49,5	30,1
5,0	350	130-170	72,1	43,9