

## MMA Electrodes Stainless and Heat resistant steels

Basic coated MMA electrode for welding similar austenitic stainless Cr-Ni-Mo steels and cast steels. The weld metal has high ductility and BASINOX 316L is recommended for welding thicker section components in all positions. Easy slag release. Applications include wet-corrosive conditions for operating temperatures <400 °C.

Classification	
EN	1600: E 19 12 3 L B 12
AWS	A5.4: E 316L-15
WR	1.4430

Approvals	Grade
DB	●
TÜV	●

CE

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Ferrite
≤ 0.025	1	0.3	≤ 0.025	≤ 0.020	18.5	11.5	2.7	5-10

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-60 °C
As Welded	≥ 420	≥ 520	≥ 30	≥ 60	≥ 32

### Materials

1.4401 (X4CrNiMo17-12-2), 1.4435 (X2CrNiMo18-14-3)

1.4571 (X6CrNiMoTi17-12-2), 1.4583 (X10CrNiMoNb18-12)

AISI 316L

### Storage

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

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	GASP	
				PC	Code
2.5	300	45-70	16.8	200	●
3.2	350	65-120	33.3	135	●
4.0	350	115-140	47.5	90	●
5.0	350	130-170	71.3	65	●