

MMA Electrodes Stainless and Heat resistant steels

BASINOX 308L T is a low hydrogen MMA electrode suitable for the welding of austenitic stainless steels. Low carbon content and very good weld metal toughness at -196°C. Efficiency 100%.

Classification	
EN	1600: E 19 9 L B 12
AWS	A5.4: E 308L-15
GOST	10052-75: ?04X20H9

Approvals	Grade
ABS	

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Ferrite
0.025	1.5	0.3	≤ 0.025	≤ 0.020	19	10	1-5

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-196 °C
As Welded	≥ 320	≥ 520	≥ 35	≥ 60	≥ 32

Materials

AISI 304 - 304L - 302

1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4311 (X2CrNi18-10)

Storage

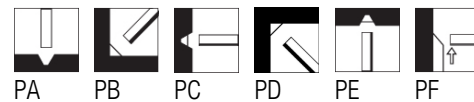
Keep dry and avoid condensation.

Re-drying not generally required.

If necessary: 280-300 °C for 1 hour, 5 times max.

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	VPMD	
				PC	Code
2.5	300	45-70	15.9	105	●
3.2	350	65-120	32.0	65	●
4.0	350	100-140	47.8	45	●