

MMA Electrodes Stainless and Heat resistant steels

Basic coated MMA electrode for welding similar stabilised austenitic stainless, Cr-Ni steels or cast steels. With the correct welding procedure, also suitable for stainless or heat-resistant ferritic Cr steels. The weld metal has high ductility and BASINOX 347 is recommended for the welding of thicker section components in all positions. Easy slag removal. Applications include wet-corrosive conditions for operating temperatures <350°C, non-scaling <800°C.

Classification	
EN	1600: E 19 9 Nb B 12
AWS	A5.4: E 347-15
WR	1.4551

Approvals	Grade
DB	●
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Nb	Ferrite
0.05	1.6	0.45	≤ 0.030	≤ 0.025	19	9.5	0.5	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	≥ 600	≥ 25	≥ 70	≥ 40

Materials

AISI 347 - 321

1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4550 (X6CrNiNb18-10);

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	
DC+	
	
	
	
PA	PB
PC	PD
PE	PF

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	GASP	
				PC	Code
2.5	300	45-70	17.7	200	●
3.2	350	65-120	33.2	135	●
4.0	350	115-140	48.2	90	●
5.0	350	130-170	76.0	65	●