

MMA Electrodes Stainless and Heat resistant steels

BASINOX 316LT is a basic coated low hydrogen MMA electrode suitable for the welding of stainless steels, types AISI 316 and 316L. Excellent mechanical properties of the weld deposit to -196°C. Efficiency 100%.

Classification		Approvals	Grade
EN	1600: E 19 12 2 B 12	ABS	
AWS	A5.4: E 316L-15		

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Ferrite
0.02	1.5	0.3	≤ 0.025	≤ 0.020	17.5	12	2.6	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	≥ 350	≥ 520	≥ 35	≥ 60	≥ 32

Materials

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

AISI 316L

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

Storage

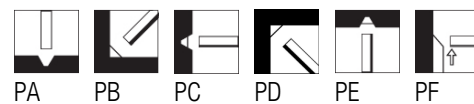
Keep dry and avoid condensation.

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)	VPMD	
				PC	Code
2.5	300	45-70	16.1	110	●
3.2	350	65-120	31.5	60	●
4.0	350	115-140	48.1	40	●