

## MMA Electrodes Stainless and Heat resistant steels

Basic-coated MMA electrode for welding ferritic-austenitic duplex steels with PREN > 40, "Superduplex", such as e.g. UNS S32550 – UNS S32760. The deposited weld metal has high strength, toughness and very good resistance to pitting and stress corrosion cracking . Used to fabricate components and pipework in the off-shore oil and gas industry and more generally for vessels and pipework in the chemical industry.

### Classification

EN	1600: E 25 9 4 N L B 42
AWS	A5.4: E 2594-15

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	N	Ferrite
0.03	0.8	0.4	≤ 0.03	0.025	25	9.5	4	0.25	35-70

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-50 °C
As Welded	≥ 650	≥ 850	≥ 20	≥ 47	≥ 32

### Materials

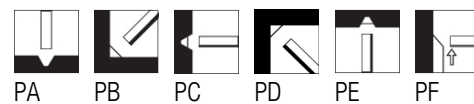
SAF 2507; Uranus 47N; UNS S32750; ASTM A182 F53

### Storage

Keep dry and avoid condensation.  
Re-drying 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	80-110	16.8	105	●
3.2	350	100-140	33.3	65	●
4.0	350	130-180	49.6	45	●