

MMA Electrodes Stainless and Heat resistant steels

SUPRANOX 308L is a rutile coated MMA electrode for welding similar austenitic stainless Cr-Ni steels, also suitable for ferritic stainless Cr-steels. Metal transfer in fine droplets and nearly spatter free, the slag is generally self releasing from finely-rippled concave fillet welds with an excellent bead surface appearance. Good striking and restriking. Under wet corrosive conditions, suitable for operating temperatures <350°C, non-scaling <800°C.

Classification	
EN	1600: E 19 9 L R 1 2
AWS	A5.4: E 308L-17

Approvals	Grade
ABS	308L
BV	UP
DB	●
DNV	308L
GL	4550
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Ni	Ferrite
≤ 0.03	0.8	0.9	19	10	5-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-120 °C
As Welded	≥ 350	≥ 520	≥ 30	≥ 50	≥ 32

Materials

1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4311 (X2CrNiN18-10)

AISI 304 - 304L - 302

Storage

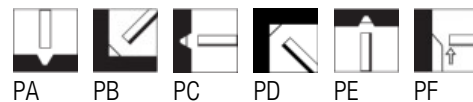
Keep dry and avoid condensation.

Re-drying not generally required.

If necessary: 300-350 °C for 2 hours, 5 times max

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX		DRYF		VPMD	
				PC	Code	PC	Code	PC	Code
2.0	300	35-60	11.0	310	●	36	●	145	●
2.5	300	45-80	17.4	195	●	28	●	90	●
3.2	350	70-120	35.1	115	●	22	●	55	●
4.0	350	100-150	53.0	75	●	18	●	35	●
5.0	450	160-220	107.1	45	●	7	●	20	●