

NICHROMA

MMA (SMAW)

RUTILE-BASIC ALL POSITION ELECTRODE FOR WELDING DISSIMILAR JOINTS

PRODUCT DESCRIPTION

A rutile-basic all position electrode for welding dissimilar joints
 The general purpose electrode for repair welding
 Suitable for hobby and professional applications
 Easy slag release and smooth bead appearance
 Also applicable for joining steels difficult to weld
 Weldable on AC and DC+ polarity

CLASSIFICATIONS

AWS A5.4	E308LMo-16
ISO 3581-A	E 20 10 3 R 3 2
APPROVALS	BV, DNVGL, TÜV, DB

ASME IX QUALIFICATION

QW432	F-No 5
QW442	A-No 8
Mat-Nr	1.4431

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G



PH/5Gu

CURRENT TYPE

AC/DC +

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	Cr	Ni	Mo	FN
Min.	--	0.5	--	18.0	8.0	2.0	--
Max.	0.10	2.5	--	21.0	11.0	3.0	--
Typical	0.025	0.8	1.0	20.0	9.5	2.3	20

ALL-WELD MECHANICAL PROPERTIES

As welded	AWS A5.4	ISO 3581-A	Typical
Tensile strength (MPa)	min. 520	min. 620	720
0.2% proof strength (MPa)	--	min. 520	500
Elongation (%)	35	20	30
Impact ISO-V(J) +20°C	--	--	70
-20°C	--	--	60

OPERATING PARAMETERS, DC +VE

Diameter (mm)	2.5	3.2	4.0
min. A	40	60	80
max. A	75	110	150

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				pack	box	pack	box
CARDBOARD BOX	2.5	350	534467	135	675	2.7	14.0
	3.2	350	534658	150	450	4.9	15.3
	4.0	350	534764	100	300	5.0	15.0