

SAFINOX R 25 20

MMA Electrodes

Stainless and Heat resistant steels



Rutile coated MMA electrode for welding identical or similar heat resistant steels. Fully austenitic microstructure, but not resistant to sulphurous gases. SAFINOX R 25 20 is an optimum choice for weldability, weld bead profile and weld metal properties.

Classification	
EN	1600: E 25 20 R 1 2
AWS	A5.4: E 310-16

CE

Chemical analysis (Typical values in %)

	C	Mn	Si	Cr	Ni
All weld metal	0.1	1.7	0.6	27	21

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Impact Energy ISO - V (J)
				+20 °C
As Welded	≥ 350	≥ 550	≥ 30	≥ 60

Materials

AISI 310; 1.4845 (X8CrNi25-21); 1.4841 (X15CrNiSi25-21); 1.4828 (X15CrNiSi20-12)

Storage

Keep dry and avoid condensation.

Re-drying not generally required

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

Current condition and welding position

AC; DC+

