

Classification

AWS A5.4	EN ISO 3581-A	GB/T 983
E308L-16	E 19 9 L R	E308L-16

Characteristics and typical fields of application

19Cr-9Ni stainless steel rutile electrode for all position welding of 1.4301/ASTM 304 type base metal. Good corrosion resistance under fairly severe conditions, e.g. in oxidation acids and cold or dilute reducing acids

Base Materials

ASTM 304, 304L; BS304S31, 304S11, 304S61; SS2333, 2352

Typical analysis of all weld metal (Wt.-%)

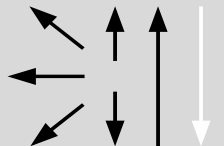
C	Si	Mn	Cr	Ni	Mo	Cu	N
0.02	0.7	0.60	19.8	9.5	0.05	0.03	0.07

Ferrite Number \approx 3-10 FN WRC 92

Mechanical properties of the weld metal

Heat Treatment	Yield strength R_e N/mm ²	Tensile strength R_m N/mm ²	Elongation ($L_0=4d_0$)	Impact work ISO-V K_V (J)		
	MPa	MPa	%	+20°C	-40°C	-120°C
As Welded	430 (\geq 320)	560 (\geq 520)	45 (\geq 30)	65 (\geq 47)	55 (\geq 47)	32 (\geq 27)

Operating Data

	Polarity DC (+) / AC	Interpass temperature : 150°C Heat Input: Max. 2.0 KJ/mm Re-drying for 3 h at 250 - 280°C
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Approval

ABS, CWB, CE

Size, Packing and Recommended welding parameters

Size (mm)	Capsule Pack		Vacuum Pack		Amperage (A)
	Kg / Pack	Kg / Box	Kg / Pack	Kg / Box	
2.50 x 350	5.00	15.00	2.00	16.00	50-80
3.25 x 350	5.00	15.00	2.00	16.00	80-120
4.00 x 350	5.00	15.00	2.00	16.00	100-160
5.00 x 450	5.00	15.00	2.00	16.00	160-220