

Classifications

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|--------------------|---------------|------------|------------|
| EN ISO 3581-A:2012 | : E 19 9 R 12 | KS D 7014 | : E308-16 |
| EN ISO 3581-B:2012 | : ES308-16 | JIS Z 3221 | : ES308-16 |
| AWS A5.4-06 | : E308-16 | | |

Description

- Covering is lime titania type for welding of 18%Cr-8%Ni stainless steel. (AISI 301, 302, 304, 308)
- Easy welding performance without hardening brittleness because of austenitic structure of the deposited weld metal.
- Good heat resistance and corrosion resistance.
- Redry the electrode at 250~350°C for 30~60 minutes prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

| C | Si | Mn | P | S | Ni | Cr | Mo | Cu |
|------|------|------|-------|-------|------|-------|------|------|
| 0.05 | 0.78 | 1.22 | 0.024 | 0.018 | 9.31 | 19.33 | 0.21 | 0.30 |

Typical mechanical properties of all-weld metal

| | Y.S (0.2%OS) (MPa) | T.S (MPa) | El. (%) | Remarks |
|---------------|-----------------------|--------------|------------|---------|
| AWS A5.4 | | min. 550 | min. 35 | |
| EN ISO 3581-A | min. 350 | min. 550 | min. 30 | |
| Example | 470 | 620 | 45 | AW |

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

| Dia. | (mm) | 2.0 | 2.6 | 3.2 | 4.0 | 5.0 |
|-------------|-------------|----------------|----------------|------------------|-------------------|--------------|
| Length | (mm) | 250 | 300 | 350 | 350 | 350 |
| Amp. (A) | F V · OH | 40~50 35~45 | 50~80 40~60 | 80~110 70~100 | 110~150 90~130 | 140~180 - |

Approvals

| ABS | BV | DNV | GL | KR |
|---------|----|-----|------|-------|
| E308-16 | UP | 308 | 4306 | RD308 |

* Others : CWB, CE