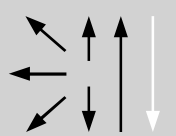


Classifications						
EN ISO 3581-A			AWS A5.4 / SFA-5.4			
E 19 9 L R 3 2			E308L-17			
Characteristics and typical fields of application						
<p>Rutile coated core wire alloyed stainless steel electrode. Suitable in all industries using similar or high carbon steels or ferritic 13% Cr-steels. Easy handling, good welding characteristics, suitable for welding on AC or DC. Other characteristics include high current carrying capacity, minimum spatter formation, self-releasing slag, smooth and clean weld profile, safety against formation of porosity due to moisture resistant coating and packaging into hermetically sealed tins.</p> <p>Resistant to intergranular corrosion up to +350 °C.</p>						
Base materials						
<p>1.4306 X2CrNi19-11, 1.4301 X5CrNi18-10, 1.4311 X2CrNi18-10, 1.4312 G-X10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10</p> <p>AISI 304, 304L, 304LN, 302, 321, 347; ASTM A157 Gr. C9, A320 Gr. B8C or D</p>						
Typical analysis of all-weld metal						
	C	Si	Mn	Cr	Ni	
wt.-%	0.03	0.80	0.80	19.80	10.20	
Mechanical properties of all-weld metal – typical values (min. values)						
Condition	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	-120 °C	-196 °C
u	<b>430</b> (≥ 320)	<b>560</b> (≥ 520)	<b>40</b> (≥ 30)	<b>70</b>	≥ 32	
sa						≥ 32
u	untreated, as welded					
sa	solution annealed and quenched					
Operating data						
	Polarity:	Redrying if necessary:	Electrode identification:	ø mm	L mm	Amps A
	DC (+)	120 – 200 °C, min. 2 h	FOX EAS 2-A	1.5	250	25 – 40
	AC		308L-17 E	2.0	300	40 – 60
			19 9 L R	2.5	250/300/350	50 – 90
				3.2	300/350	80 – 120
				4.0	350/450	110 – 160
			5.0	450	140 – 200	
Approvals						
<p>TÜV (01095.), DB (30.014.15), ABS, DNV GL, Statoil, VUZ, CE, CWB, NAKS (ø 3.2 mm; ø 4.0 mm)</p>						