

Classifications

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