

Flux-coated Electrode for Welding of Stainless Steel Types AISI 304 & Equivalent Grades

Description:

Precisely controlled chemistry of the core wire and the flux coating enables consistent achievement of outstanding weld metal properties. Extra Low carbon content of the weld metal ensures freedom from intergranular corrosion. High deposit ductility and optimum ferrite content always assures freedom from hot cracking without sacrificing corrosion resistance.

Typical Applications:

For joining and cladding applications on 18 Cr / 8 Ni type stainless steels with normal or high carbon content.

Unique Features:

- Excellent operating features and easy slag control in all positions.
- Smooth, well-rippled weld beads with negligible spatter.
- Conforms to ASME Sec II, Part C, SFA 5.4, Class E 308H-16.

Technical Properties:

Typical All-weld Chemistry (Wt %):

C	Mn	Si	Cr	Ni	S	P
0.060	0.75	0.30	19.80	10.40	0.010	0.03

Typical Mechanical Properties:

Tensile Strength : 600 MPa

Elongation (L=4D) : 40%

Other Properties:

Delta Ferrite Content : 2 – 6 FN

Welding Procedure:

Clean the weld area. Bevel heavy sections 60 Deg to 90 Deg Vee. Clamp/tack long seams. Use chill bars and back-up plates to minimise distortion. Deposit stringer beads with shortest arc length. Chip slag between passes. Prevent localised heat build-up by staggered welding.

Welding Parameters:

Size (mm)	2.50	3.15	4.0	5.0
Amps	50 - 80	70 - 110	90 - 140	130 - 180

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