



Product Data Sheet

E 'Manual metal-arc welding'

OK 61.30

Signed by Claes Gillenius	Approved by Tapio Huhtala/Barbro Karlström	Reg no EN003063	Cancelling EN002760	Reg date 2005-10-24	Page 1 (2)
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REASON FOR ISSUE

Welding current range revised. UDT approval deleted.

GENERAL

Extra low carbon stainless steel electrode for welding steels of the 19 Cr 10 Ni-type.

Also suitable for welding stabilized stainless steels of similar composition, except when the full creep resistance of the base material is to be met.

Min AC OCV: 50

Polarity: DC+, AC

Alloy Type: Austenitic CrNi

Coating Type: Acid Rutile

Ferrite Content: FN 3-10

WELDING POSITIONS



CLASSIFICATIONS Electrode

EN 1600	E 19 9 L R 1 2
SFA/AWS A5.4	E308L-17
CSA W48	E308L-17
Werkstoffnummer	1.4316

APPROVALS

ABS	Stainless
CL	EN 1600
CWB	CSA W48
DB	30.039.02
DNV	308L
Sepros	UNA 409820
SS	EN 1600
VdTÜV	00792
Ü	30.039

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C		0.030
Si	0.50	0.90
Mn	0.50	1.20
P		0.025
S		0.020
Cr	18.5	20.5
Ni	9.0	11.0
Mo		0.5
Cu		0.5



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MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal			AWS	
	ISO			As welded	
	Min	Max	Typ	Min	Max
Rp0.2 (MPa)	350		430	350	
Rm (MPa)	550	700	560	550	700
A4 (%)				35	
A5 (%)	32		43		
Z (%)			60		
Charpy V at 20°C (J)	47		70		

Comments:

Interpass temp. at welding <150 °C.

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	N	B	H	T	U
Ø x Length	Min	Max							
1.6 x 300	35	45	0.7	105	0.55	240	0.6	24	27
2.0 x 300	35	65	1.2	105	0.55	160	0.8	29	29
2.5 x 300	50	90	1.8	105	0.55	99	1.1	36	31
3.2 x 350	70	130	3.9	105	0.60	49	1.4	54	31
4.0 x 350	90	180	5.2	105	0.60	33	2.0	60	32
5.0 x 350	140	250	8.0	105	0.60	20	3.0	60	33

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)

OTHER DATA

Redrying: 350 °C, 2h.