

CLASSIFICATION

AWS A 5.4	IS 5206	BS 2926	DIN 8556
E308L -16	E19.9.LR26	E19.9LR	E19.9LR23

CHARACTERISTICS

A rutile coated stainless steel electrode has extra low carbon and approx. 8% Ferrite. It gives smooth shiny weld bead, with easy re-striking and easy removable slag. This electrode gives radiographic welds with excellent creep strength and applied for all 18/8 type stainless steel at service temperature of -120°C up to +350°C.

APPLICATIONS

For welding of AISI 301, 302, 304L & 308L steels household's articles, hospital apparatus, kitchen equipment soap, diary, brewery industry etc. Dump impellers, for building-up stainless surfaces on centrifugal pump impellers and shafts, valve faces, seats and chemical plants, pharmaceutical equipment, architectural fabrication etc.

SPECIAL INSTRUCTION

Available in Vacuum Pack .Please Re dry the electrode at 250°C for one hour .If the packet is open for 12 hours or more ,5 times max. Do not use excessive currents. Use good fit-up joints. Adopt proper sequence. Remove the slag with a stainless steel wire brush.

WELDING POSITION



1G



2F



3G



4G

CHEMICAL COMPOSITION OF ALL WELD METAL

Element	C	Mn	Si	S	P	Cr	Ni
Percent (max)	0.04	0.50-2.50	0.80	0.010	0.03	18.0 -21.0	9.0 - 11.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (N/mm ²)	Elongation %
550 - 650	35 min

CURRENT CONDITION : AC/DC(+)

Size (mm)	Ø 2.50	Ø 3.20	Ø 4.00	Ø 5.00
Current (Amps)	55 - 90	85 - 110	130 - 150	150 - 190

PACKING DETAILS

DIA (mm)	Ø 2.50	Ø 3.20	Ø 4.00	Ø 5.00
LENGTH (mm)	350	350	350	350
WEIGHT /PKT (Kg)	2	2	2	2
PKT / BOX	5	5	5	5
WEIGHT /BOX (Kg)	10	10	10	10



TECHWELD INDUSTRIAL TECHNOLOGIES LTD

3rd Floor, 120 Baker Street, W 1 U6TU

Email : info@techweld.co.uk

Website : www.techweld.co.uk

