

Type of Covering: Lime-titania
Welding Position: F, H, HF, OH, V
Type of Current: DCEP or AC

Features & Applications

It is used for welding stainless steel structures that fabricated by 022Cr19Ni10 or 06Cr18Ni11Ti (e.g. 304L or 308L) stainless steels, which work temperature ≤ 300 °C, such as facilities of synthetic fibre, fertilizer, petrochemical equipment and so on. The weld metal has good resistance to intercrystalline corrosion.

Chemical Composition of Deposited Metal (%)

	C	Mn	Si	Cr	Ni	Mo	Cu	S	P
Standard	≤ 0.04	0.50-2.50	≤ 1.00	18.0-21.0	9.0-11.0	≤ 0.75	≤ 0.75	≤ 0.03	≤ 0.04
Typical	0.029	0.86	0.63	19.80	9.60	0.078	0.10	0.012	0.024

Mechanical Properties of Deposited Metal (AW)

	Tensile Strength Rm (MPa)	Elongation A4 (%)
Standard	≥ 520	≥ 35
Typical	575	46

Sizes Pieces & Recommended Current (DC+ or AC)

Size (mm)	2.0 x 300	2.5 x 300	3.2 x 350	4.0 x 400	5.0 x 400	
Pieces (2kg)	≈ 172	≈ 110	≈ 57	≈ 33	≈ 22	
Current (A)	F, H	30-50	50-85	85-120	120-160	150-200
	V, OH	30-50	50-70	70-100	90-135	—

Approvals

Institute	CWB
Grade	CSA W48 E308L-16

- Notice:**
- 1) The rod should be baked at 300 -350 °C for 1 hour before use.
 - 2) The surfaces to be welded must be cleaned away impurities of oil contamination, moisture and so on.
 - 3) Smaller current and short arc are recommended in welding and weave beads no wider than 2.5 times of the diameter of the core rod is better.