

COVERED ELECTRODES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SS-307 is a titanium oxide low hydrogen electrode, the weld metal contains 18%Cr-8%Ni-4%Mn as the full austenitic structure.
- It is suitable for clad stainless steel, high tensile steel, steels difficult to weld, nuclear submarine, and armor plate at a non-magnetic site.

NOTE ON USAGE :

- Re bake the electrodes at 250 ~ 300°C for 1 hour and keep it at 100~150°C prior to use.
- With lower current is to properly keep the dilution of the parent metal for welding crack.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr	Mo
0.089	4.3	0.45	0.028	0.004	9.62	19.5	0.8

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
610(62.2)	40

SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		300	350	350	350
Current (Amp)	F	50-85	80-120	100-150	140-170
	V & OH	45-80	70-110	90-135	-