

COVERED ELECTRODES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SS-308L is a titanium oxide low hydrogen electrode, the weld metal contains 19%Cr-9%Ni the austenitic structure.
- It is suitable for Petrol Chemical Industry, Pressure Vessel, Food and Beverage Machinery, and the stainless steels such as AISI 301, 302, 304S, and SUS 304 or 304L.

NOTE ON USAGE :

- Rebake 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
0.024	1.15	0.58	0.030	0.005	9.51	19.60

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
600(61.2)	41

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	140-180
	V & OH	45-80	70-110	90-135	-