Selectarc WELDING

SELECTARC Inox 308HR

High Efficiency Stainless Steel Electrode

Classification

AWS A5.4 : E308L - 26
ISO 3581- A : E 19 9 L R 73
EN 1600 : E 19 9 L R 73

Characteristics

Synthetic electrode with high recovery (160%). Rutile-basic coating with a deposit of 19%Cr - 9%Ni stainless steel type. Easy striking of arc, soft arc, clean spatter-free welds, self lifting slag. Concave, finely rippled fillet welds. Fast deposition, long beads. To use on similar (304 type) grade stainless steels.

Applications

For Tubes, Tanks, Stainless Steel Constructions

Base materials

UNS	ALLOY	EN 10088	Material N°	UGINE
S30400	304	X5CrNi 18-10	1.4301	UGINOX 18-9 B, D, E
S30403	304L	X2CrNi 19-11	1.4306	UGINOX 18-10 L
S32100	321	X6CrNiTi18-10	1.4541	UGINOX 18-10 T
S34700	347	X6CrNiNb 18-10	1.4550	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	S	P	Fe
0.030	0.90	0.70	19.00	9.50	0.025	0.025	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R_m (MPa)	YS $R_{p0.2}$ (MPa)	% Elg A_5	Impact (KV) Temp.°C	J	FN (WRC)
AW	570	365	35	+ 20	60	6

Welding Current & Instructions

Electrode	ØxL (mm)	1.6 x 250	2.0 x 350	2.5 x 350	3.2 x 350	4.0 x 350
Current	(A)	40 - 60	50 - 70	80 - 100	120 - 140	160 - 180

Redrying of electrodes at 250°C for 1hr if necessary. Maintain Inter-pass temperature : < 200°C.



1G/PA 2F/PB

AC/+	~ 70V

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