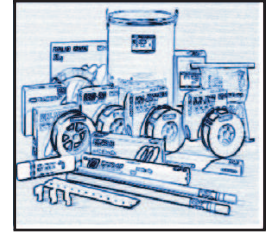


ANU BOND 1A (E 308-16)

Classification : ASME / AWS A 5.4, E 308-16
IS : 5206 E 19.9R 26



Features : This is normal carbon 19/9 stainless steel electrode with ferrite Content of 3 to 7% for maximum resistant to cracking upto 800 Degree centigrades. Used for welding grades AISI 301,302,304 & 308 composition.

Redrying Conditions: 300~350 x 1 hrs

■ **Chemical composition of all-weld metal (%) as per AWS**

	C	Si	Mn	P	S	Cr	Ni
Typical	0.08	1.00	0.5 - 2.50	0.040	0.030	20.0	10.0
Example	0.05~0.12	0.85~1.0	0.25~0.65	0.030 .0.025	-	18.0-21.0	9.0-11.0

■ **Mechanical properties of all-weld metal as per AWS**

	YP (MPa)	TS (MPa)	EI (%)
Typical	500	550	35
Example	480	530	33

■ **Recommended welding parameters**

Dia.	2.5mm	3.15mm	4.0mm
F, HF, H, VD	45~95A	60~125A	105~170A
VU, OH	45~95A	60~125A	100~150A

■ **Polarity**

Example	AC
Guaranty	AC, DC-EP, DC-EN

■ **Approval**

■ **Packages**

Dia. (mm)	Length (mm)	Kg per Pack (Kgs)	Pack per Carton (No. of Packs)	Kgs per Carton (Kgs)
2.50	350	2	6	12
3.15	350	2	6	12
4.00	350	2	6	12

