

Shielded Metal Arc Welding

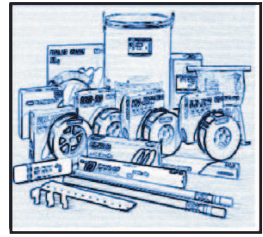
ANU BOND -1C (E 308L - 16)

AWS:SFA 5.4, E308L-16 IS : E19 - 9 LR -16

Stainless Steel Electrodes

Application :

Ideally suited for welding of stainless steel AISI grade 301, 302, 304, 304L, 308, 308L composition. For welding of household articles, milk and soap industries, Hospital apparatus, nuclear plant. Food stuff and chemical process industries.



Characteristics on Usage :

An extra low carbon titania all position 19 Cr- 10 Ni stainless steel electrode which is highly resistance. Intergranular, corrosion, cracking, oxidation and scaling very smooth running with extremely smooth removal of slag leaving a uniform and fine rippled bead characterized by excellent all round performance and weld metal properties up to 250 °C.

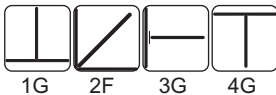
Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	S	P	Cr	Ni	Cu
0.040 Max	0.50-2.0	0.75 Max	0.030 Max	0.040 Max	18.0-21.0	9.0-11.0	0.75 Max

Mechanical properties of all-weld metal as per AWS

UT.S	Elongation
(N/mm ²)	(L=4d) %
520 Min	35 Min

Welding Positions



Packaging & Welding Current

SIZE (mm)	KG Per Packet	KG Per Carton	Current (Amps)	In Amps
2.50 x 350	2	12	DC (+)	45-85
3.15 x 350	2	12		85-115
4.00 x 350	2	12		100-140
5.00 x 350	2	12		140-180

