



Product Data Sheet

E 'Manual metal-arc welding'

OK 61.30

Prepared by A-C Thorsson	Qualified by Tero Borg	Approved by Tapio Huhtala	Reg no EN007233	Cancelling EN007127	Reg date 2016-05-12	Page 1 (2)
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REASON FOR ISSUE

Approvals revised.

GENERAL

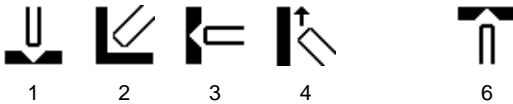
Extra low carbon stainless steel electrode for welding steels of the 19 Cr 10 Ni-type.

Also suitable for welding stabilized stainless steels of similar composition, except when the full creep resistance of the base material is to be met.

Min AC OCV: 50
Polarity: DC+, AC

Alloy Type: Austenitic CrNi
Coating Type: Acid Rutile
Ferrite Content: FN 3-10

WELDING POSITIONS



CLASSIFICATIONS Electrode

EN ISO 3581-A E 19 9 L R 1 2
SFA/AWS A5.4 E308L-17
CSA W48 E308L-17
Werkstoffnummer 1.4316

APPROVALS

ABS Stainless
CE EN 13479
CWB CSA W48: E308L-17
DB 30.039.02
DNV-GL VL 308 L
NAKS/HAKC 2.0-4.0 mm
Seproz UNA 272580
VdTÜV 00792

APPROVAL COMMENT

Approvals valid for lot numbers starting with SB.

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max	Nom
C		0.030	
Si	0.50	1.00	
Mn	0.50	1.20	
P		0.025	
S		0.020	
Cr	18.5	20.5	
Ni	9.0	11.0	
Mo		0.5	
Cu		0.5	
N		0.15	
Ferrite FN			5



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MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO			AWS	
	Min	Max	Typ	Min	Max
As welded					
Rp0.2 (MPa)	320		430	320	
Rm (MPa)	520	700	580	520	700
A4 (%)			45	35	
A5 (%)	33		60		
Z (%)					
Charpy V at 20°C (J)	47		70		
Charpy V at -60°C (J)	32		49		

Comments:

Interpass temp. at welding <150 °C.

ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
1.6 x 300	35	45	0.7	105	0.55	240	0.6	24	27	1,2,3,4,6
2.0 x 300	35	65	1.2	105	0.55	160	0.8	29	29	1,2,3,4,6
2.5 x 300	50	90	1.8	105	0.55	99	1.1	36	31	1,2,3,4,6
3.2 x 350	70	130	3.9	105	0.60	49	1.4	54	31	1,2,3,4,6
4.0 x 350	90	180	5.2	105	0.60	33	2.0	60	32	1,2,3,4,6
5.0 x 350	140	250	8.0	105	0.60	20	3.0	60	33	1,2,3

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)

OTHER DATA

Hardness data:

As welded condition, all weld metal, transverse cross section of ISO joint, measurements done along a horizontal- (5 indents) and vertical line (10 indents), 2 samples tested: 174 - 237 HV10, average 204 HV10

Redrying: 350 °C, 2h.