



## **M90 E308**

### **FEATURES**

- \*GOOD CREEP RESISTANCE
- \*SERVICE TEMPERATURE UP TO 350°C
- \*EASY TO REMOVE SLAG
- \*LOW SPATTER
- \*GOOD BEAD APPEARANCE

### **APPLICATION**

- \*Rutile-basic all position stainless steel electrode. Used for welding low-carbon stainless steels of the type AISI 304 in cases where maximum resistance to intergranular corrosion is required.
- \*For welding Titanium and Niobium stabilized stainless steels. Weld able on both AC and DC.

### **CLASSIFICATION**

- \*AWS/A5.4/ ASME SFA5.4 E308-16

### **CHEMICAL COMPOSITIONS**

C	Si	Mn	P	S	CR	Ni	MO
0.05	0.80	1.0	0.03	0.029	20.0	9.9	2.5

### **MECHANICAL PROPERTIES**

Y.S	T.S	EL	Temp.	CVN-Impact Value
N/mm2 (lbs/in 2 )	N/mm2 (lbs/in 2 )	(%)	oC ( oF)	J (ft lbs)
576 (83,500)	576 (83,500)	49.8	-196(-321)	36(27)

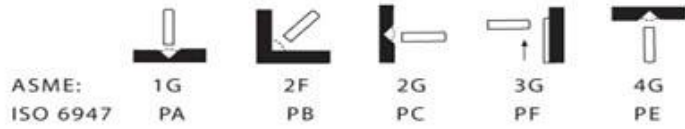
### **WELDING PARAMETERS**

DIAMETER (mm)	1.6	2	2.5	3.2	4	5
LENGTH (mm)	300	300	350	350	350	350
CURRENT (amps)	20-55	25-55	50-85	70-110	95-145	135-190

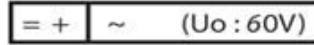
### **CURRENT**

- \*AC or DC +/-

## WELDING POSITIONS



*Current*



## FOR STAINLESS STEEL