



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)

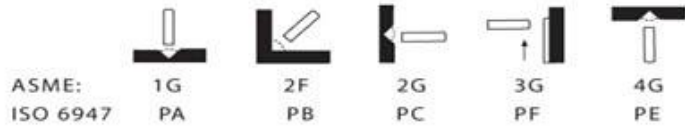
WELDING PARAMETERS

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