



## **M-90 E308L**

### **FEATURES**

- \*GOOD RESISTANCE TO CORROSION AND OXIDIZING ENVIRONMENTS
- \*EASY TO REMOVE SLAG
- \*GOOD BEAD APPEARANCE
- \*HIGH MOISTURE RESISTANCE (17TYPE)

### **APPLICATION**

- \*Rutile-basic coated electrode for welding non stabilized and stabilized corrosion resistant austenitic Cr-Ni steels up to 350°C.
- \*Smooth metal transfer with both AC and DC. Weld metal beads exhibit fine ripple formation.
- \*Focused and stable arc with low spatter loss.
- \*Self-detaching slag.
- \*Moisture resistant formulation producing welds free from porosity.

### **CLASSIFICATION**

- \*A5.4/ ASME SFA5.4 E308L-16

### **CHEMICAL COMPOSITIONS**

C	Si	Mn	P	S	CR	Ni	MO
0.02	0.80	0.75	0.03	0.029	18.9	9.9	2.5

### **MECHANICAL PROPERTIES**

T.S	EL
N/mm2 (lbs/in 2 )	(%)
562 (81,600)	47

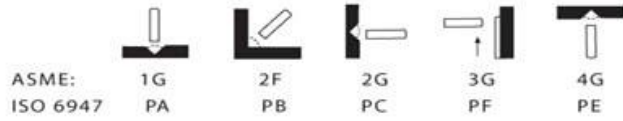
### **WELDING PARAMETERS**

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

= +	~	(U <sub>0</sub> : 60V)
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