



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

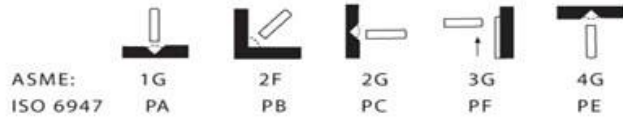
WELDING PARAMETERS

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 ₀ : 60V)
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