



M-90 ER308

FEATURES

- *RESISTANCE TO CRACK
- *HIGH EFFICIENCY
- *RESISTANCE TO CORROSION

APPLICATION

STEEL STRUCTURE-OIL, TEXTILE INDUSTRIES, NUCLEAR REACTION

CLASSIFICATION

*A5.9/ ASME SFA5.9 ER308

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Ni	MO
0.04	0.41	1.75			19.9	9.8	

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)
	610 (88,500)	40	0 (32)	130(95)

WELDING PARAMETERS

DIAMETER (mm)	1.6	2.4
LENGTH (mm)	1000	1000
CURRENT (amps)	50-70	70-100

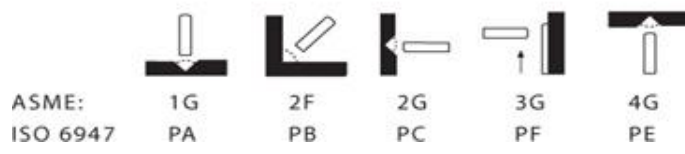
CURRENT

*DC -

GAS

Ar

WELDING POSITIONS



Current

= +	~	(U _o : 70 V)
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