

Standards

TS EN ISO 3581-A	: E 19 9 L B 22
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AWS A5.4	: E 308 L-15

**Chemical Composition of
Weld Metal % (Typical)**

C	Si	Mn	Ni	Cr
0.02	0.45	1.2	10.3	19.7

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 370	520 - 660	90 J	min. 40

Typical Base Material Grades

- X2CrNi 19 11, X5CrNi 18 10, X6CrNiTi 18 10, X6CrNiNb 18 10, X 10 CrNiNb 18 10, X2CrNiN 18 10, X12CrNi 18 8, 304L, 304, 304 LN, 321, 347, 302, 320 B 8 C & D

Features and Applications

- Low carbon alloyed core wire austenitic electrode with basic coating for use in all industries where similar steel types, including higher carbon grades as well as ferritic 13% -Cr steels are welded.
- High ductility of the weld metal, therefore preferably used for welding heavy sections.
- Very good out-of-position weldability.
- Good low-temperature ductility down to -196°C.
- Resistant to intergranular corrosion up to 350°C.
- Weld metal does not require preheating or postweld heat treatment.

Welding Positions

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101023	2.50 x 250	3/32 x 10"	50-80	1510
3010101028	3.20 x 350	1/8 x 14"	80-110	3330
3010101033	4.00 x 350	5/32 x 14"	110-140	4760

Approvals: TSE, CE, SEPRO