

**Standards**

TS EN ISO 3581-A	: E 19 9 H R 32
EN ISO 3581-A	: E 19 9 H R 32
AWS A5.4	: E 308 H- 16

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

C	Si	Mn	Ni	Cr
0.07	0.7	0.8	10.4	19.0

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/+20°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)
min. 355	550 - 650	min. 47 J	min. 35

**Typical Base Material Grades**

- DIN; X5CrNi18 -10, X6CrNiTi18-10, X6CrNiNb18-10, X8CrNiTi18-10, X7CrNi18-9
- AISI; 304, 304H, 321, 321H, 347, 347H

**Features and Applications**

- Electrode with rutile coating on alloyed core-wire
- Applicability in welding Cr-Ni alloyed austenitic high - temperatures steel
- Usability in welding at all positions except for vertical downward position
- Applicability in joint-welding and surfacing of heat-resisting similar-type steels and steel casting
- Serviceability at temperatures of values up to 700°C
- Resistance to fracture and corrosion
- Creep resistance at high temperatures being higher than that of the electrode GeKa ELOX R 308 L

**Welding Positions**

**Current Type**

D.C.(+) / A.C

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101008	2.50 x 250	3/32 x 10"	50 - 80	1490
3010101013	3.20 x 350	1/8 x 14"	80 - 110	3430
3010101018	4.00 x 350	5/32 x 14"	110-140	5060

**Approvals:** TSE, CE, SEPRO