

Standards

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

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

C	Si	Mn	Ni	Cr
0.03	0.8	0.9	10.5	20.0

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 355	520 - 660	min. 47 J	min. 35

Typical Base Material Grades

- X2CrNi 19 11, X5CrNi 18 10, X6CrNiTi 18 10, X6CrNiNb 18 10, X2CrNiN 18 10, X10CrNiNb 18 10, X12CrNi 18 8, 304 L, 304, 304 LN, 321, 347, 302

Features and Applications

- Rutile-coated low-carbon electrode for use in chemical, petrochemical and food industries where similar steel types, including higher carbon grades as well as ferritic 13% -Cr steels are welded. Resistant to corrosion and cracks. Working temperatures up to +350°C
- Requirement of Re-drying for min. 2 hours at the temperatures between 120°C and 200°C

Welding Positions

Current Type

D.C.(+)/ A.C

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100963	2.50 x 250	3/32 x 10"	50 - 90	1500
3010100968	3.20 x 300	1/8 x 12"	80 - 120	2930
3010100973	3.20 x 350	1/8 x 14"	80 - 120	3510
3010100978	4.00 x 350	5/32 x 14"	110 - 160	5100

Approvals: TSE, CE, BV, ABS, SEPRO