

Standards

TS EN ISO 3581-B	: ES308LMo-16
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AWS A5.4	: E308LMo-16

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

C	Mo	Ni	Cr
0.03	2.5	9.5	18.0

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 450	540 - 700	min. 47 J	min. 35

Typical Base Material Grades

- ASTM A351-Gr. CF3M steel casting.

Features and Applications

- A rutile electrode for welding of dissimilar steels
- The general purpose electrode for repair welding
- It has easy slag removal and smooth appearance in filled welding

Welding Positions

Current Type

D.C.(+) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100988	3.20 x 350	1/8 x 14"	80 - 120	3510

Approvals: CE, SEPRO