Standards

TS EN ISO 3581-A	: E 19 9 Nb R 32
EN ISO 3581-A	: E 19 9 Nb R 32
AWS A5.4	: E 347-16

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Ni	Cr	Nb
0.04	0.8	0.9	10.0	19.8	+

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20°C)	Elongation ($L_0=5d_0$) (%))
min. 390	570-740	min. 47 J	min. 35

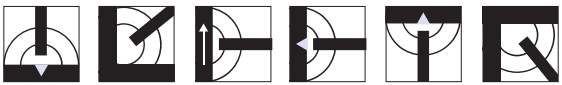
Typical Base Material Grades

- EN: X6CrNiNb 18 10, X6CrNiTi 18 10, G-X5CrNiNb 18 9, X5CrNi 18 10, X12CrNiTi 18 9, G-X10CrNi 18 8, X10CrNiNb 18 10, X2CrNi 19 11
- AISI: 347, 321, 304, 304LN

Features and Applications

- Used for the welding of tanks and pipes in which milk and beer is kept
- Also used for the welding of acid, gas, steam and water armatures
- Resistant to acid and corrosion, stabilized by Nb. Weld metal can resist to temperatures up to +400°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
3010101388	2.00 x 250	5/64 x 10”	40 - 60	940
3010101393	2.50 x 250	3/32 x 10”	50 - 90	1500
3010101398	3.20 x 300	1/8 x 12”	80 - 120	2980
3010101403	3.20 x 350	1/8 x 14”	80 - 120	3470
3010101408	4.00 x 350	5/32 x 14”	110 - 160	5150

Approvals: TSE, CE, SEPRO