

Standards

TS EN ISO 3581-A	: E 19 12 2 R 53
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AWS A5.4	: E316-26

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

C	Si	Mn	Mo	Ni	Cr
0.07	0.9	1.0	2.7	11.0	18.5

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
min. 410	640-740	min. 55 J	min. 30

Typical Base Material Grades

- EN: X5CrNiMo 17 13 3, X10CrNiMo 18 10, X6CrNiMoTi 17 12 2, X5CrNiMo 17 12 2, G-X10CrNiMo 18 10,
- AISI: 316, 316Ti, 317

Features and Applications

- Used for welding of Cr-Ni-Mo alloyed steels, joint of stainless steel to carbon steels and used for surfacing of stainless steel on carbon steels
- The efficiency of weld metal is approx. 150%
- It is synthetic electrode and is resistant to high current
- 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
3010101298	2.50 x 350	3/32 x 14"	90 - 120	3310
3010101303	3.20 x 350	1/8 x 14"	110 - 160	5480
3010101308	4.00 x 350	5/32 x 14"	150 - 190	8080
3010101313	5.00 x 350	3/16 x 14"	180 - 220	11400

Approvals: TSE, CE, SEPRO