Stanvac INTERNATIONAL

Product Data Sheet

Rutile electrode — STAVINOX 308L

Classification

***AWS A* 5.4:** E 308L-16 ***DIN 8556*:** E 19 9 LR 23

DIN EN 1600: E 19 9 L R 32 ***Werkstoff Nr:*** 1.4316

Description and applications

Low carbon Rutile-basic-coated 19Cr, 10Ni austenitic stainless steel electrode with controlled ferrite approx 8% for maximum resistance to cracking and corrosion. Core wire is 308LER with controlled 'P' & 'S'. Coating with very low moisture pick up. Soft fusion without spatters, very easy slag removal exceptional weld bead appearance, easy restriking. Applied for all 18/8type stainless steels at service temperature from -120°C upto + 350°C tubes, tanks, heat exchangers, piping systems…..

Base materials

Stainless steels for general use:				
UNS	**Alloy**	**EN 10088**	**Material N[a]**	**UGINE**
S30400	304	X5CrNi18-10	1.4301	UGINOX 18-9 B, D, E
S30403	304L	X2CrNi19-11	1.4306	UGINOX 18-10 T
S30800	308	X2CrNi18-10	1.4300	UGINOX 19- 11 B, D, E
S30803	308 L	X2CrNi 19-11	1.4300	UGINOX 19-11 B,D,E
S32100	321	X6CrNiTi18-10	1.4541	UGINOX 18-10 T
S34700	347	X6CrNiNb18-1O	1.4550	

All weld metal mechanical properties (typical)

Tensile Strength R_m (N/Mm^2)	Elongation %	ISO- V J RT
610	44	60

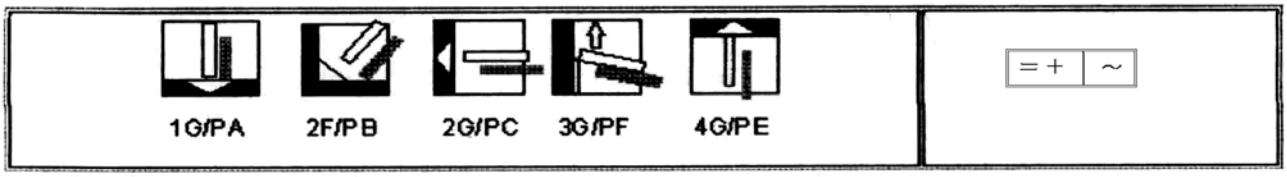
Typical weld metal Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	S	P
< 0.03	0.70	1.00	19.0	10.0	---	0.010	0.015

Amperes (A)

2.50	3.15	4.00	5.00
50-80	80- 110	110- 150	150- 180

Welding instruction interpass temperature :< 200°C. Rebaking if necessary 1 hour at 300°C.



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