

**Standards :**

TS EN ISO 3581 - A	:	E 19 9 LR 32
EN ISO 3581 - A	:	E 19 9 LR 32
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 <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/+20 °C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> )(%)
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

Re-drying : 300-350 °C / min. 2 h

**Welding Positions :**

**Current Type :**

D.C.(+)

A.C.

**Operating Data :**

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
2.50 x 250	3/32 x 10"	50 - 90	1500
3.20 x 300	1/8 x 12"	80 - 120	2930
3.20 x 350	1/8 x 14"	80 - 120	3510
4.00 x 350	5/32 x 14"	110 - 160	4935

**Approvals :**

TSE, BV, CE, ABS, GOST-R, SEPRO, HAKC (3.20 mm), CWB