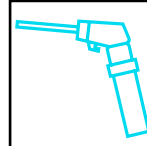


# WELDING CONSUMABLES

## STAINLESS STEEL AND SPECIAL ELECTRODES



## SECTION THREE

### SATINCROME 308L-17

45  
OCVAC  
DC+

#### TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

0.2% Proof Stress	500 MPa
Tensile Strength	630 MPa
Elongation	40%
CVN Impact Values	75J av @ +20°C.

#### TYPICAL ALL WELD METAL ANALYSIS:

C: 0.025%	Mn: 0.76%	Si: 0.87%
Cr: 20.4%	Ni: 9.8%	S: 0.010%
P: 0.017%		

#### FERRITE NUMBER:

3.0 - 10.0 FN\*

\* - using Severn Gauge

#### APPROVALS:

American Bureau of Shipping AWS A5.4: E308L-17.

#### COMPARABLE CIGWELD PRODUCTS:

Autocraft 308LSi GMAW wire  
AWS A5.9: ER308LSi.  
Comweld 308L Gas/TIG wire  
AWS A5.9: ER308L.  
Shieldcrome 308LT & FCAW wires  
AWS A5.22: E308LT1-1/4

- ▲ Rutile Type, Stainless Steel Electrode.
- ▲ Outstanding Operator Appeal. Improved slag lift.
- ▲ All Positional (except vertical down) Welding Capabilities.
- ▲ Applications include the single and multi-pass welding of 19Cr/10Ni type stainless steel grades including 201, 202, 301, 302, 303, 304, 304L, 305, 308 etc.

#### Classifications:

AS/NZS 1553.3: E308L-17.

AWS/ASME-SFA A5.4: E308L-17.

#### Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	300	47	40 - 70	2.5kg	15kg - 6 x 2.5kg	611602
2.5	300	47	40 - 70	1kg	12kg - 12 x 1kg	610602
3.2	350	28	75 - 110	2.5kg	15kg - 6 x 2.5kg	611603
3.2	350	28	75 - 110	1kg	12kg - 12 x 1kg	610603
4.0	350	18	110 - 150	2.5kg	15kg - 6 x 2.5kg	611604
4.0	350	18	110 - 150	1kg	12kg - 12 x 1kg	610604

### MUREX™ SPEEDEX 308L-16

45  
OCVAC  
DC+

#### TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	500 MPa
Tensile Strength	630 MPa
Elongation	40%
CVN Impact Values	75J av @ +20°C

#### TYPICAL ALL WELD METAL ANALYSIS:

C: 0.03%	Cr: 20 %	Mn: 0.76%
Ni: 10%	Si: 0.87%	

#### COMPARABLE CIGWELD PRODUCTS:

Autocraft 308LSi GMAW wire  
AWS A5.9: ER308LSi.  
Comweld 308L Gas/TIG wire  
AWS A5.9: ER308L.  
Shieldcrome 308LT & FCAW wires  
AWS A5.22: E308LT1-1/4

- ▲ A E308L-16 type stainless steel electrode.
- ▲ Designed for fillet & butt welding in all positions except vertical-down.
- ▲ Offers low spatter levels with smooth running.
- ▲ Ideal for welding 304 and 304L stainless steel grades.
- ▲ Applications include the all position (except vertical-down) welding of stainless steel tanks, vessels, componentry.

#### Classifications:

AS/NZS 1553.3: E308L-16.

AWS A5.4: E308L-16.

#### Packaging and Operating Data:

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	300	55	40 - 70	2.5kg	15kg - 3 x 2.5kg	SPS30825
3.2	350	30	75 - 110	2.5kg	15kg - 3 x 2.5kg	SPS30832
4.0	350	19	110 - 150	2.5kg	15kg - 3 x 2.5kg	SPS30840

### SATINCROME 309Mo-17

45  
OCVAC  
DC+

#### TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

0.2% Proof Stress	500 MPa
Tensile Strength	620 MPa
Elongation	35%
CVN Impact Values	60 J av @ +20°C.

#### TYPICAL ALL WELD METAL ANALYSIS:

C: 0.05%	Mn: 0.75%	Si: 0.9%
Cr: 23.0%	Ni: 13.0%	Mo: 2.2%
S: 0.012%	P: 0.017%	

#### FERRITE NUMBER:

15.0 - 20.0 FN\*

\* - using Severn Gauge

#### APPROVALS:

American Bureau of Shipping AWS A5.4: E309Mo-17.

#### COMPARABLE CIGWELD PRODUCTS:

Autocraft 309LSi GMAW wire  
AWS A5.9: ER309LSi.  
Comweld 309L Gas/TIG wire  
AWS A5.9: ER309L.  
Shieldcrome 309LT & FCAW wires  
AWS A5.22: E309LT1-1

- ▲ Rutile Type, Stainless Steel Electrode.
- ▲ Outstanding Operator Appeal. Improved slag lift.
- ▲ All Positional (except vertical down) Welding Capabilities.
- ▲ Applications include the single and multi-pass welding of matching 309 and 309L stainless steels. Also suitable for the dissimilar welding of other "300 series" austenitic stainless steels and selected "400 series" ferritic grades to mild or low alloy steels.

#### Classifications:

AS/NZS 1553.3: E309Mo-17.

AWS/ASME-SFA A5.4: E309Mo-17.

#### Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	300	52	40 - 70	2.5kg	15kg - 6 x 2.5kg	611692
2.5	300	52	40 - 70	1kg	12kg - 12 x 1kg	610692
3.2	350	30	75 - 110	2.5kg	15kg - 6 x 2.5kg	611693
3.2	350	30	75 - 110	1kg	12kg - 12 x 1kg	610693
4.0	350	19	110 - 150	2.5kg	15kg - 6 x 2.5kg	611694
4.0	350	19	110 - 150	1kg	12kg - 12 x 1kg	610694