

Standards :

TS EN ISO 3581 - A	:	E 19 9 Nb B 22
EN ISO 3581 - A	:	E 19 9 Nb B 22
AWS A5.4	:	E 347 - 15

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

C	Si	Mn	Ni	Cr	Nb
0.04	0.45	1.4	10.2	19.8	0.4

Mechanical Properties :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20 °C)	Elongation (L ₀ =5d ₀)(%)
min. 400	600-740	min.55 J	min. 30

Typical Base Material Grades :

* X6CrNiNb 18 10, X6CrNiTi 18 10, X5CrNiNb 18 10, X5CrNi 18 10, X2CrNiN 18 10, X2CrNi 19 11,
G-X5CrNiNb 19 10, G-X10 CrNi 18 8, 347, 321, 304, 304L, 304LN, 302, A296 CF 8 C, A 157 C9, A 320 B 8 C and D.

Features and Applications :

- * Stabilized alloyed-core wire austenitic electrode with basic coating for use in all industries where similar steel types as well as ferritic 13% chromium steels are welded.
- * High ductility of the weld metal, therefore preferable for welding heavy sections.
- * Very good out-of-position weldability Good low-temperature-ductility down to -196 °C.
- * Resistant to intergranular corrosion up to 400 °C.
- * Weld metal does not require preheating or postweld heat treatment.
- * Re-drying : 150-200 °C / 2h

Welding Positions :



Current Type :

D.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"	60-80	1400
3.20 x 350	1/8 x 14"	80-120	3150
4.00 x 350	5/32 x 14"	100-150	4775

Approvals :

TSE, CE, GOST-R, SEPRO