

Standards :

TS EN ISO 3581 - A	:	E 19 9 Nb R 32
EN ISO 3581 - A	:	E 19 9 Nb R 32
AWS A5.4	:	E 347 - 16

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

C	Si	Mn	Ni	Cr	Nb
0.04	0.8	0.9	10.0	19.8	+

Mechanical Properties :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20 °C)	Elongation (L ₀ =5d ₀)(%)
min. 390	570-740	min.47 J	min. 35

Typical Base Material Grades :

* X6CrNiNb 18 10, X6CrNiTi 18 10, G-X5CrNiNb 18 9, X5CrNi 18 10, X12CrNiTi 18 9, G-X10CrNi 18 8, X10CrNiNb 18 10, X2CrNi 19 11, 347, 321, 304, 304 LN

Features and Applications :

- * Used for the welding of tanks and pipes in which milk and beer is kept.
- * Also used for the welding of acid, gas, steam and water armatures.
- * Resistant to acid and corrosion, stabilized by Nb. Weld metal can resist to temperatures up to +400°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
2.00 x 250	5/64 x 10"	40-60	940
2.50 x 250	3/32 x 10"	50-90	1540
3.20 x 300	1/8 x 12"	80-120	2980
3.20 x 350	1/8 x 14"	80-120	3470
4.00 x 350	5/32 x 14"	110-160	5150
5.00 x 350	3/16 x 14"	140-220	7700

Approvals :

TSE, CE, GOST-R, SEPRO