

COVERED ELECTRODES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SS-308LT is a titanium oxide low hydrogen electrode, the weld metal contains 19%Cr-9%Ni the austenitic structure.
- It possesses of great Impact property at -196°C.
- It is suitable for Petrol Chemical Industry, Pressure Vessel, Food and Beverage Machinery, and the stainless steels such as AISI 301, 302, 304S, SUS 304L, and lower temp. storage tank.

NOTE ON USAGE :

- Re bake the electrodes at 250 ~ 300°C for 1 hour and keep it at 100~150°C prior to use.
- With lower current is to properly keep the dilution of the parent metal for welding crack.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Cr
0.038	1.13	0.60	0.030	0.009	10.01	18.75

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	IMPACT VALUES -196°C J(Kgf-m)	SIDE EXPANSION (mm)
575(58.6)	41	35(3.6)	0.8

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		300	350	350	350
Current (Amp)	F	50-85	80-120	100-150	140-180
	V & OH	45-80	70-110	90-135	-