

Rutile basic electrode with a very low carbon concentration, designed for austenitic stainless steels without molybdenum, type 18/8 (304, 304L). It is very resistant to corrosion in oxidised environments and can be used in all positions. It is recommended for the first pass in all cases where regular penetration and compacity are necessary.

■ Classification

EN 1600 / ISO 3581-A: E 19 9 LR
AWS A 5.4 : E 308 L-17

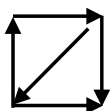
■ Applications

- Petrochemical, chemical, marine & food industries.
- Pipes and tanks.

■ Benefits

- Soft arc.
- The weld bead aspect.
- Stainless steel welding 304, 308, 188 and 1883.
- Easy slag removal .
- Very resistant to corrosion in oxidised environments.

■ Positions and polarity



- Ignition from 40V - Direct current.
- **Electrode polarity (+).**

■ Chemical properties

C %	Mn %	Si %	S%	P %	Cu %	Ni %	Cr %	Mo %
0.03	0.70	0.70	0.015	0.015	0.05	10.00	19.00	0.10

■ Mechanical properties

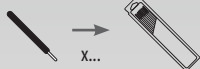
Re	Rm	A 5 d	KV + 20°C
350 MPa	520 MPa	35%	80 J

■ Approval

Ø électrode (mm)	2,0	2,5
thickness (mm)	-	3 ▶ 6
welding current (A)	45	40 ▶ 80



Packaging

Ref.	Ø (mm)	length (mm)	
073692	Ø 2.0	300	14
082328	Ø 2.5	300	10