

INOX B308L CRYO

Electrodes MMA [SMAW]

Stainless and high alloyed steels

CLASSIFICATION: EN ISO 3581-A : E 19 9 L B 42 DIN 8556 : E 199L B 42 AWS A-5.4 : E308L-15 W.Nr. : 1.4316	APPROVALS:	APPLICATION: Petrochemical and chemical industry
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- Low carbon austenitic 308 type electrode with basic coating.
- Ferrite content about 8%.
- Stable arc, good slag removal.
- It is characterized by very good mechanical properties.
- Designed for materials operating at temperatures from -196°C to +350°C.

Base material

AISI/ASTM	EN 10088-1/2	W.Nr.	PN
304L	X2 CrNi 18 11	1.4306	00H18N10
304LN	X2 CrNiN 18 10	1.4311	
	X4 CrNi 18 10		
	X6 Cr 13	1.4308	
304	X5 CrNi 18 10	1.4301	0H18N9
321	X6 CrNiTi 18 10	1.4541	1H18N9T, 0H18N10T,1H18N10T
347	X6 CrNiNb 18 10	1.4550	H18N12Nb
		1.4552	
302	X12 CrNi18 8	1,4300	
305		1.4312	
304H	X6 CrNi18 11	1.4948	
308	X5 CrNi18 11	1.4303	
347	X5 CrNiNb18 9	1.4543	
301		1.4310	1H18N9
	X10 CrNiNb18 10	1.6905	
405	X7 CrAl13	1.4002	
410	X10 Cr13	1.4006	1H13
430	X8 Cr17	1.4016	H17
410/420	X15 Cr13	1.4024	
420	X20 Cr13	1.4021	2H13
305	G-X10 CrNi18 8	1.4312	

Typical chemical composition %

C	Si	Mn	Cr	Ni
<0,04	0,40	1,60	19,00	9,50

Typical mechanical properties

Yield strength Re [N/mm²]	>320
Tensile strength Rm [N/mm²]	>510
Elongation A5 [%]	>30
Impact energy Kv [J]	>30J (-196°C) /

Coating type	basic
Welding current	

Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]
2,5	350 /	70A	1,5	9,0
3,2	350 /	90A	1,5	9,0

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