

Rutile electrode

SUPER OPTIMAL 308L

Classification **AWS A 5.4:** E 308L-16 **DIN 8556:** E 19 9 LR 23
DIN EN 1600: E 19 9 L R 32 **Werkstoff Nr:** 1.4316

Description and applications Low carbon Rutile-basic-coated 19Cr, 10Ni austenitic stainless steel electrode with controlled ferrite approx 8% for maximum resistance to cracking and corrosion. Core wire is 308LER with controlled 'P' & 'S'. Coating with very low moisture pick up. Soft fusion without spatters, very easy slag removal exceptional weld bead appearance, easy restriking. Applied for all 18/8type stainless steels at service temperature from -120°C upto + 350°C tubes, tanks, heat exchangers, piping systems.....

Base materials

Stainless steels for general use:				
UNS	Alloy	EN 10088	Material N ^a	UGINE
S30400	304	X5CrNi18-10	1.4301	UGINOX 18-9 B, D, E
S30403	304L	X2CrNi19-11	1.4306	UGINOX 18-10 T
S30800	308	X2CrNi18-10	1.4300	UGINOX 19- 11 B, D, E
S30803	308 L	X2CrNi 19-11	1.4300	UGINOX 19-11 B,D,E
S32100	321	X6CrNiTi18-10	1.4541	UGINOX 18-10 T
S34700	347	X6CrNiNb18-1O	1.4550	

All weld metal mechanical properties (typical)

Tensile Strength R _m (N/Mm ²)	Elongation %	ISO- V J RT
610	44	60

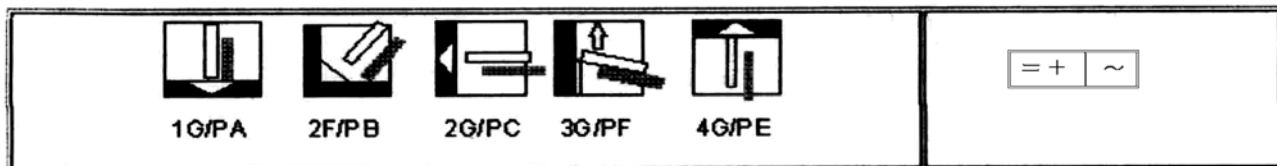
Typical weld metal Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	S	P
< 0.03	0.70	1.00	19.0	10.0	---	0.010	0.015

Amperes (A)

2.50	3.15	4.00	5.00
50-80	80- 110	110- 150	150- 180

Welding instruction interpass temperature :< 200°C. Rebaking if necessary 1 hour at 300°C.



The image shows five welding position icons labeled 1G/PA, 2F/PB, 2G/PC, 3G/PF, and 4G/PE. To the right is a power source symbol indicating DC (+) and AC (~).

**Stainless steel
Rutile type electrode**

SUPER OPTIMAL 308L-17

Classification	AWS A 5.4: E 308L-17	DIN 8556: E 19 9 LR 23
	DIN EN 1600: E 19 9 L R 32	Werkstoff Nr: 1.4316

Description and applications Low carbon Rutile-silica-coated 19Cr, 10Ni austenitic stainless steel electrode with controlled ferrite approx 6-8% for maximum resistance to cracking and corrosion. Core wire is 308LER. Coating with very low moisture pick up. Soft fusion without spatters, very easy slag removal exceptional weld bead appearance, easy restriking. Applied for all 18/8type stainless steels at service temperature from - 120°C upto + 350°C tubes, tanks, heat exchangers, piping systems.....

Packed in vacpack system.

Base materials

Stainless steels for general use:				
UNS	Alloy	EN 10088	Material N ^a	UGINE
S30400	304	X5CrNi18-10	1.4301	UGINOX 18-9 B, D, E
S30403	304L	X2CrNi19-11	1.4306	UGINOX 18-10 T
S30800	308	X2CrNi18-10	1.4300	UGINOX 19- 11 B, D, E
S30803	308 L	X2CrNi 19-11	1.4300	UGINOX 19-11 B,D,E
S32100	321	X6CrNiTi18-10	1.4541	UGINOX 18-10 T
S34700	347	X6CrNiNb18-10	1.4550	

All weld metal mechanical properties (typical)

Tensile Strength R _m (N/mm ²)	Elongation %	ISO- V J RT
610	38	60






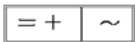
Typical weld metal Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	S	P
0.03	0.90	0.80	19.0	9.50	0.10	0.010	0.025

Amperes (A)

2.50	3.15	4.00	5.00
50-70	70- 100	100- 140	140- 170

Welding instruction interpass temperature :< 200°C. Rebaking if necessary 1 hour at 300 /350°C.

					
1G/PA	2F/PB	2G/PC	3G/PF	4G/PE	