



CRONI 18/8

STAINLESS STEEL ELECTRODE

CLASSIFICATION :

IS : 5206-83 : E 19.9R26
AWS/A 5.4 : E 308-16

CHARACTERISTICS :

A rutile type stainless steel electrode suitable for welding of 18Cr-8Ni grade stainless steels. The weld-metal has high resistant to corrosion and scaling. Operates equally well on AC or DC(+) in all conventional positions. Excellent and consistent performance with respect to chemical and mechanical properties.

APPLICATIONS :

- * Welding of AISI 301, 302, 304 and 308 Grades.
- * Surfacing of 18/8 and Clad Steels of Similar Composition.

RECOMMENDATIONS :

To obtain best results redry the electrodes at 200°C. Use low current, short arc, stringer bead technique. Control interpass temperature to 175°C max. Use stainless wire brush for cleaning the weld.

CHEMICAL ANALYSIS OF WELD-METAL(%) :

C	Mn	Si	Cr	Ni	Mo	S	P	Cu
0.08	0.5-2.5	1.0	18-21	9-11	0.75	0.03	0.04	0.75
max		max			max	max	max	max

MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER AWS/A 5.4) :

Ultimate Tensile Strength	Elongation (GL=4d) (%)	CVN Impact Value at 27°C
N/mm ²		Joules
550 min	35 min	70 min

CURRENT CONDITIONS : USE AC (70V) OR DC (+)

Size (mm)	2.5x350	3.15x350	4.0x350	5.0x350
Amps	60-80	80-110	110-140	150-180

SPECIAL CHARACTERISTICS :

DELTA FERRITE : 5-10 FN

**MODI ARC ELECTRODES CO.**

Modinagar - 201 204 (U.P.)

Fax : 01232 - 242147

Phone : (01232) 325700, 325925, 243912

E-mail : modiarc@ndb.vsnl.net.in

Web Site : www.modielectrodes.com