



SS-308

STAINLESS STEEL ELECTRODE

CLASSIFICATION :

IS : 5206 : 83 : E19.9 R 26
AWS/A 5.4 : E 308-16

APPROVALS :

PDIL, BHEL, UHDE INDIA LTD, EIL, NPC, TOYO

CHARACTERISTICS :

A rutile type stainless steel electrode suitable for welding of AISI 304, 308 grade stainless steels. The weld metal is highly resistant to corrosion, scaling and temperatures upto 800°C. Operates equally well on AC or DC (+) in all conventional positions. Excellent and consistent performance as well as 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 for one hour. Use low current, short arc and stringer bead technique. Control interpass temperature to 150°C max. Use stainless steel wire brush for slag removal.

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	CVN Impact
N/mm ²	GL=4d (%)	Values at 27°C
550 min	35 min	Joules 70 min

CURRENT CONDITIONS : USE AC 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.

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SS 308 L

STAINLESS STEEL ELECTRODE

CLASSIFICATION : IS : 5206-83 : E19.9 LR 26
AWS/A 5.4 : E 308L-16

APPROVALS : NPC, UHDE INDIA LTD, BHEL, DNV, PDIL, TOYO

CHARACTERISTICS : A low heat input stainless electrode designed to yield a weld deposit of extra low carbon. The special type of coating ensures better mechanical properties and excellent operating characteristics. The weld metal has high resistance to corrosion, oxidation and scaling even at high temperature - upto 800°, operates equally well on AC or DC(+), in all conventional positions of low OCV and at low current resulting into low heat input.

APPLICATIONS :

- * Joining of AISI 304L, 308L
- * Normal Carbon Grades like 302, 304 & 308
- * Welding of Clad Steel of Similar Composition
- * Overlays in Un-alloyed, Low Alloy Steels etc.

RECOMMENDATIONS : Re-dry the electrodes at 200°C for one hour. Use low current, short arc and stringer bead technique. Maintain interpass temperature below 150°C.

CHEMICAL ANALYSIS OF WELD-METAL(%) :	C	Mn	Si	Cr	Ni	Mo	S	P	Cu
	0.04	0.5-2.5	1.0	18-21	9-11	0.75	0.03	0.04	0.75
			max			max	max	max	max

MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER AWS/A 5.4) :	Ultimate Tensile Strength	Elongation	CVN Impact
	N/mm ²	GL=4d (%)	Values at 27°C
	520 min	35 min	Joules
			70 min

CURRENT CONDITIONS : USE AC 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



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SS 308 L-15

STAINLESS STEEL ELECTRODE

CLASSIFICATION : AWS/A 5.4 : E 308 L-15

CHARACTERISTICS : A basic type stainless steel electrode designed to yield a weld deposit of extra low carbon. The special type of coating ensures better mechanical properties and excellent operating characteristics. The weld metal has high resistance to corrosion, oxidation and scaling even at high temperature upto 800°C. Operates on DC (+) in all conventional positions.

APPLICATIONS :

- * Joining of AISI 301L, 302L, 304L, 308L Grades.
- * Normal Carbon Grades like 302, 304 & 308.
- * Welding of Clad Steels of similar composition.
- * Overlays in un-alloyed, low alloy steels etc.

RECOMMENDATIONS : Re-dry the electrodes at 250°C for one hour. Use low current, short arc and stringer bead technique. Maintain interpass temperature below 150°C max. Use stainless steel wire brushes for cleaning the welds.

CHEMICAL ANALYSIS OF WELD-METAL(%) :	C	Mn	Si	Cr	Ni
	0.04 max	0.5-2.5	1.0 max	18-21	9-11
	Mo	Cu	S	P	
	0.75 max	0.75 max	0.03 max	0.04 max	

MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER AWS/A 5.4) :	Ultimate Tensile Strength (N/mm ²)	Elongation (GL=4d) (%)	CVN Impact Value at -196°C Joules
	520 min	35 min	30

CURRENT CONDITIONS : USE DC (+) ONLY

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



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