Stanvac INTERNATIONAL

Product Data Sheet

Stainless steel

STAVINOX E308 -15

Classification ***AWS A* 5.4:** E 308-15 **ISO EN 3581-A:** E 19 9 B 4 2

Description and applications

Low carbon Rutile-basic-coated 19Cr, 10Ni austenitic stainless-steel electrode with controlled ferrite approx. 4-8% for maximum resistance to cracking and corrosion. Coating with very low moisture pick-up. Soft fusion without spatters, very easy slag removal exceptional weld bead appearance, easy restriking. Applied for all 18/8 types stainless steels at service temperatures from -120°C up to + 350°C tubes, tanks, heat exchangers, and 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)

Yield Strength R_m (N/mm^2)	Tensile Strength R_m (N/mm^2)	Elongation A_5%	ISO- V J -60ºC
>350	590	40	50

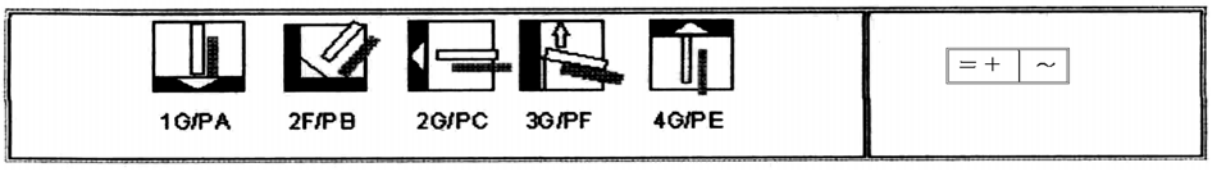
Typical weld metal Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	S	P
0.030	0.80	0.90	19.0	10.00	0.10	0.010	0.025

Amperes (A)

2.00	2.50	3.15	4.00	5.00
45-55	50-80	80- 110	110- 150	150- 180

Welding instruction Inter-pass temperature :< 150°C. Rebaking is necessary 1 hour at 300 /350°C.



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