



Cromarod 308LP

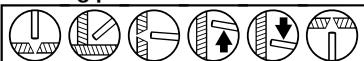
SMAW - (Stick) - MMA
Stainless Steel

Date: 2009-02-27
Revision: 11

Description:

Cromarod 308LP is a fully-positional rutile coated electrode specially designed for applications requiring optimum positional operability. It is intended for stainless steel grades 304L and 304, but can also be used for the stabilised grades 347 and 321. With its exceptionally good arc stability, weld pool control and striking/re-striking characteristics it is highly suitable for the most demanding vertical and overhead pipewelding applications. The relatively thin coating and fast-freezing slag make Cromarod 308LP particularly advantageous to use when welding thinner walled material. For structural applications at temperatures above 400 °C, Cromarod 308H is recommended because of its superior strength properties at elevated temperatures.

Welding positions:



Coating type:

Rutile

Welding current:

DC +, AC 0CV > 39V

Ferrite content:

FN 5 (WRC-92)

Redrying temperature:

350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0,5			18,0	9,0
Typical	0,02	0,7	0,6	0,02	0,02	19,7	9,5
Max	0,030	1,0	2,0	0,030	0,025	21,0	11,0

	Mo	Cu	V	Nb
Min				
Typical	0,1			
Max	0,5	0,5	0,1	0,1

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	450 MPa
Tensile Strength, Rm:	≥ 550 MPa	580 MPa
Elongation, A5	≥ 35%	40%
Impact energy, CV:		0 °C • 60 J -60 °C • 50 J

Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,0	300	74292000	20-45	21	0,67	148	0,7	40
2,5	300	74292500	35-85	21	0,68	91	0,9	45
3,2	350	74293200	40-100	23	0,73	44	1,4	53

Classification:

EN 1600	E 19 9 L R 11
AWS A5.4	E 308L-17
ISO 3581-A	E 19 9 L R 11

Approvals:

CE

Note

Core wire:
P ≤ 0.020%
S ≤ 0.015%
N ≤ 0.080%