



Cromarod B308L

SMAW - (Stick) - MMA
Stainless Steel

Date: 05/30/2013
Revision: 6

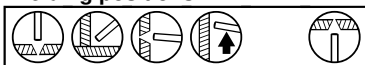
Description:

Basic coated stainless steel electrode for type 304L/304LN steel grades. Produces weld metal with higher toughness at lower temperatures compared to rutile coated electrodes. The basic coating results in higher resistance to porosity due to improved gas shield, making the electrode highly suitable for on site welding. Cromarod B308L has an easy slag removal even in narrow joint preparations, reducing post-weld cleaning time.

Applications:

Offshore, pipeline, restrained joints.

Welding positions:



Coating type:

Basic

Welding current:

DC+

Ferrite content:

FN 5 (WRC 92)

Metal recovery:

110%

Redrying temperature:

350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0,8			18,0	9,0
Typical	0,03	0,35	1,0	0,02	0,01	19,0	10,0
Max	0,04	0,50	1,2	0,030	0,025	21,0	11,0

	Mo	Cu
Min		
Typical	0,03	0,1
Max	0,5	0,5

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 320 MPa	430 MPa
Tensile Strength, Rm:	≥ 520 MPa	570 MPa
Elongation, A5	≥ 30%	40%
Impact energy, CV:		-50 °C • 80 J -196 °C • 50 J lat exp 0.6 mm

Classification:

AWS A5.4 E308L-15
ISO 3581-A E 19 9 L B 42

Approvals:

CE
DNV

Note

For fixed pipe position PF/5G, electrode diameter 3,25 mm is the max recommended size.

Core wire:
 $P \leq 0.020\%$
 $S \leq 0.015\%$
 $N \leq 0.080\%$

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.)
2,5	300	74262500	50-80	24	0,69	86	0,83	43
3,2	350	74263200	75-125	25	0,69	43	1,24	59
4,0	350	74264000	100-165	26	0,69	28	1,94	60

