MAC STAIN E101 ELC

Description & Applications:

High quality rutile type stainless steel electrode for welding low carbon 19% Cr, 9% Ni stainless steel. The extra low carbon content provides improved corrosion resistance and notch toughness at low temperatures. Wide usage in the pressure vessel, process plant, dairy and food industries, also suitable for cryogenic applications where high notch toughness at sub-zero temperatures is required. Although the electrode is primarily for welding steels of the AISI 304L and 308L types, it may also be used for welding the higher carbon types 304 and 308. In applications where the operating temperature does not exceed 400◦C the electrode may also be used for welding type 347 steels.

Related Specification:

AWS E308L-17

Typical All Weld Metal Chemical Analysis %:

C	Mn	Si	Cr	Ni
0.03	1.1	0.62	18.5	10.1

Weld Metal Micro-Structure:

Austenite with 3-10% ferrite.

Typical All Weld Metal Mechanical Properties:
As Welded

Ultimate Tensile Strength	585 N/mm²
0.2% Proof stress	340 N/mm²
Elongation on 4d	30-45 %
Reduction of area	40-55 %
Hardness	140-170 Brinell
Charpy Vee Notch +20◦C	80 Joules
Charpy Vee Notch -196◦C	48 Joules

Current:

AC/DC (+)

Sizes Available and Recommended Amperages:

1.50mm	2.00mm	2.50mm	3.25mm	4.00mm	5.00mm
25-35	30-45	45-70	70-110	110-140	140-180

Storage:

If allowed to become damp the electrodes should be re-dried for one hour at 250°C before use.

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