



## MAC STAIN E103CF

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### ■ **Description & Applications:**

High quality rutile type stainless steel electrode for welding steels of a similar composition. The deposited weld metal has a controlled carbon content of about 0.08% and a low ferrite level, therefore increasing the high temperature strength and stability of the welds microstructure in service conditions above 400°C. Normally used in furnace and flue gas systems.

	BS	ASTM/AISI	DIN 1.4832
CAST	309C30	CH8	(G-X 25 CrNiSi 20 14)
WROUGHT	309S24	309	(X 12CrNi 22 12)

### ■ **Related Specification:**

AWS E309-16

### ■ **Typical All Weld Metal Chemical Analysis %:**

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.08	1.5	0.3	0.01	0.02	22.8	12.9	0.1	0.1

### ■ **Typical All Weld Metal Mechanical Properties:**

#### As Welded

Ultimate Tensile Strength	600 N/mm <sup>2</sup>
0.2% Proof Stress	480 N/mm <sup>2</sup>
Elongation on 4d	40 %
Reduction of Area	50 %
Hardness	210 HV

### ■ **Current:**

AC/DC (+).

### ■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
60-80	70-110	90-150	130-200

### ■ **Storage:**

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