



# Selectarc 308HR

*High Efficiency  
Stainless Electrode*

## Classification

AWS A5.4 : E308L-26      EN 1600 : E 19 9 L R 7 3  
ISO 3581-A : E 19 9 L R 7 3

## Description & Applications

Synthetic electrode with high recovery (160%)-Rutile-basic coating with a deposit of 19%Cr - 9%Ni stainless steel type. Easy striking, soft arc, clean spatter-free welds, slag lifts by itself, concave finely rippled fillet welds. Fast deposition, long beads. To use on similar (304 type) stainless steels.

**Main applications:** For tubes, tanks, stainless steel constructions

### Base materials

#### Stainless steels for general use:

UNS	Alloy	EN 10088	Material N°	UGINE
S30400	304	X5CrNi18-10	1.4301	UGINOX 18-9 B, D, E
S30403	304L	X2CrNi19-11	1.4306	UGINOX 18-10 L
S32100	321	X6CrNiTi18-10	1.4541	UGINOX 18-10 T
S34700	347	X6CrNiNb18-10	1.4550	

## Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Ni	Fe
<0.04	0.9	0.7	19	9.5	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
>360	>550	>35	+20°C >60

## Welding Current & Instructions

Electrode	ØxL ( mm )	1,6x250	2,0x350	2,5x350	3,2x350	4,0x450
Current	( A )	50	60	90	120	150

Redrying at 300°C during 1h, if necessary. Interpass temperature : < 150°C.

ind.12



= + ~ 55V

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