



Selectarc 20/10BC

*Stainless Steel
Rutile Electrode*

Classification

AWS A5.4 : E308L-16 EN 1600 : E 19 9 L R 3 2
ISO 3581-A : E 19 9 L R 3 2

Description & Applications

Low carbon Rutile-basic-coated austenitic stainless steel electrode with approx. 8% ferrite. Coating with very low moisture pick up. Soft fusion without spatters, very easy slag removal, exceptional weld bead appearance, easy restriking. Applied for all 18/8 type stainless steels at service temperatures from -120°C up to +350°C.

Main applications: Tubes, tanks, heat exchangers, piping systems.

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
<0.03	0.8	0.7	19.0	9.5	Rem.

All Weld Metal Mechanical Properties

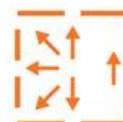
R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
>360	>540	>35	+20°C >70

Welding Current & Instructions

Electrode	ØxL (mm)	2,0x300	2,5x300	3,2x350	4,0x350	5.0x450
Current	(A)	45	70	100	135	180

Redrying at 250°C during 1h, if necessary. Interpass temperature: < 150°C.

ind.12



= + ~ 70V



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