



# Selectarc Inox 308Mo

*Stainless Electrode  
For repairing*

## Classification

AWS A5.4 : ~ E308Mo-17  
ISO 3581-A : E 20 10 3 R 3 2

EN 1600 : E 20 10 3 R 3 2

## Description & Applications

Rutile-basic coated stainless steel type electrode with an austenitic-ferritic structure used to weld dissimilar joints between construction / mild steels and stainless steels. Due to its high level of delta ferrite ( ~25% ) also used as an universal repairing electrode in maintenance welding. Highly crack resistant. Soft fusion, nice aspect of the beads, slag lifts by itself.

## Base materials

UNS	Alloy	EN 10088	Mat. N°	UGINE
S31600	316	X5CrNiMo17-12-2	1.4401	UGINOX 17-10 M
S31603	316L	X2CrNiMo17-12-2	1.4404	UGINOX 18-11 ML
J92900		G-X5CrNiMo19-11-2	1.4408	
S31635	316Ti	X6CrNiMoTi17-12-2	1.4571	UGINOX 17-11 MT
S31635	316Ti	X10CrNiMoTi18-12	1.4573	
S31640	316Cb	X6NiCrMoNb17-12-2	1.4580	
		G-X5CrNiMoNb19-11-2	1.4581	

+ for dissimilar joints between low alloy/mild steels and stainless steels.

## Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Ni	Mo	Fe
0.04	0.8	1.0	20.5	10.5	3.0	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
>450	>620	>30	+20°C >50

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x300	3,2x350	4,0x350
Current	( A )	50-80	80-115	90-140

Redrying 1 hour at 250°C if necessary. Interpass temperature : < 150°C.

ind.13



= + ~ 70V



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