

**Електроди Esab заваръчни 2.5x300 мм, 1.7 кг, 90 А,
неръждаеми, ОК 63.30**



SMAW

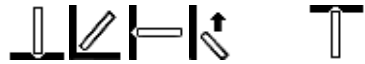
Type Acid-rutile

Extra low carbon stainless steel electrode for welding steels of the 18Cr 12Ni 2.8Mo-type.

Also suitable for welding of stabilized stainless steels of similar composition, except when the full creep resistance of the base metal is to be met.

Welding current

DC+, AC OCV 50 V



Classifications	Approvals		Typical all weld metal composition, %		Typical mech. properties all weld metal	
EN 1600	ABS	E316L-17	C	<0,03	Yield stress, MPa	
E 19 12 3 L R 1 2	CWB	CSA	Si	0,75	460	
SFA/AWS A5.4		W48	Mn	0,9	Tensile strength, MPa	
E316L-17	DB	30.039.06	Cr	18,0	570	
Werkstoff Nr.	DNV	316L	Ni	12,0	Elongation, %	
1.4430	GL	4571	Mo	2,8	40	
CSA W48	LR	316L	Cu	<0,2	Elongation, %	
E316L-17	Sepros	UNA			Ferrite content	
		272580			FN 3-10	
	VdTUV	00262			Charpy V	
	CE	EN 13479			Test temps, °C	Impact values, J
	BV	316L			+20	60
					-20	55
					-60	43

Diameter, mm	1,6	2,0	2,5	3,2	4,0	5,0
Length, mm	300	300	300	350	350	350
Arc voltage, V	29	29	29	30	32	32
Welding current, A	30-45	45-65	45-90	60-125	70-190	100-280
N. Kg weld metal/kg electrodes	0,56	0,60	0,56	0,55	0,56	0,56
B. No. of electrodes/kg weld metal	250	147	96	52	34	21
H. Kg weld metal/hour arc time	0,4	0,6	1,1	1,4	2,0	3,0
T. Burn-off time, s/electrode	37	39	45	57	57	63

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