

EIS 307

Coated Electrode for Stainless Steels -

Standards

AWS/ASME SFA - 5.4	~E307-26
EN ISO 3581 - A	E 18 8 Mn R 53
TS EN ISO 3581 - A	E 18 8 Mn R 53
DIN M. No.	1.4370

Approvals & Certificates

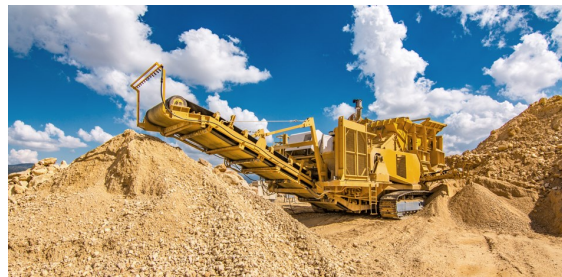
CE

Materials

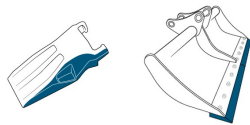
EN	Material	ASTM
X3CrNiMo17-13-3	1.4436	316
X5CrNiMo17-12-2	1.4401	316

Properties and Applications

High efficiency (160 %) electrode for joining dissimilar steels and depositing buffer layer before hardfacing and claddings on ferritic steels. The weld metal consists of austenitic Cr-Ni-Mn steel with possible small amounts of delta ferrite. The weld metal is highly crack resistant and therefore suited for joining difficult to weld steels and depositing stress relaxing buffer layers on crack sensitive base metal prior to hardfacing deposits. Weld metal work hardens by impact and pressure. Suitable for armour plates, rail, cross-overs, crane wheels, idlers, which are subjected to dynamically loading, pressure, impact and abrasion. It is non-scaling up to 850°C and highest operating temperature for dissimilar steel joints is 300°C. In the case of higher temperatures, use ENI 422 electrodes. High current carrying capacity due to its low alloy steel core wire and possible to use equally well both with AC and DC.



Typical Applications






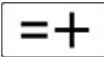

Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn	Cr	Ni
Weld Deposit	0.07	1.00	6.50	19.50	9.50

Typical Mechanical Values of Weld Metal

Test Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	440	610	40	20°C → 70

Application Information

Welding Positions  PA  PB  PC			Polarity:  		
Welding Parameters & Efficiency					
Diameter x Length (mm)	Current (A)	Weld Deposit(Kg)/1Kg Consumed Electrode	Number of Electrodes/1Kg Weld Deposit	Weld Metal Deposition Rate (Kg/h)	Efficiency(%)
4.00x350	150-200	0,62	23	1,74	149
5.00x350	180-230	0,62	16	2,16	150
6.00x350	220-270	0,62	9	2,68	150
3.25x350	110-160	0,63	36	1,22	151
2.50x350	80-100	0,64	57	0,89	158

Packaging Information

Product Code	Diameter X Length (mm)	Pieces per Box (-)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package	Packaging Type
13002HDEM2	2.50x350	98 kg	2.5	3	8.1	Plastic Box
13002HJEM2	2.50x350	78 kg	2.0	10	21.0	VAC Box
13002NDEM2	3.25x350	57 kg	2.5	3	8.1	Plastic Box
13002NJEM2	3.25x350	46 kg	2.0	10	18.6	VAC Box
13002QDEM2	4.00x350	36 kg	2.5	3	8.1	Plastic Box
13002QJEM2	4.00x350	29 kg	2.0	10	20.9	VAC Box
13002TDEM2	5.00x350	25 kg	2.5	3	8.1	Plastic Box
13002TJEM2	5.00x350	20 kg	2.0	10	18.6	VAC Box

Storage & Re-Drying Information

It can be dried maximum 5 times.
It has to be dried at 350°C for 2 hours.