



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 _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	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.

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= + ~ 70V



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