



Stainless Steel Electrode

Commodity	Stick Electrode					
Technique	Stainless Steel					
Technical Specification	AWS/SFA	YIELD STRENGTH N/MM2	TENSILE STRENGTH N/MM2	ELONGATION A5(%)	IMPACT V (J) - 30°C	WELDING CONDITIONS
	E 308L-16		≥550	≥35	≥ 60	AC/DC (+)
	E310-16	≥350	≥550	≥30	≥70	AC/DC (+)
	E312-16	> 500	> 700	> 24	-	AC/DC (+)
	E316L-16		≥580	40	60	AC; DC+
	E 318 - 16	≥450	≥590	≥30	65	AC; DC+
	E 347-16		≥550	≥35	60	AC; DC+
	E 385-16	≥400	≥550	≥35	≥60	AC; DC+
	E2209-15	≥550	≥750	≥25	≥60	-
	E410-15	≥250	≥520	≥22	-	-
	E430-15	≥300	≥500	≥20	-	-
	E 309L-16	≥350	≥550	≥35	≥47	-
Size	Key	Min/mm	Max/mm			
	Ø	2.40	9.50			
	Lenth	350	450			
Surface Finish	ROUND / The coating is low-hydrogen iron powder, TiO2, CaCO3, and CaF2 (calcium fluoride). The coating is of medium thickness, and the addition of iron powder increases deposition. It freezes relatively fast to enable flat, horizontal, vertical-up, and overhead welding.					
PACKAGE	Plastic Box Tube pack (Vacuum Packed & & normal pack)					
APPLICATION	A SS electrode is a good choice for stick welding stainless steel, especially for maintenance or repair applications. It offers high cracking resistance and good strength, and typically can join stainless steel already in service, even if the specific material grade isn't known.					