

EI 308MO

Coated Electrode for Stainless Steels -

Standards

| | |
|--------------------|----------------|
| AWS/ASME SFA - 5.4 | E308Mo-15 |
| EN ISO 3581 - A | E 20 10 3 B 22 |
| TS EN ISO 3581 - A | E 20 10 3 B 22 |
| DIN M. No. | 1.4443 |

Approvals & Certificates

GOST

Properties and Applications

Basic electrode, particularly designed for welding armour plates, dissimilar steels and for surfacing purposes. The weld metal consists of austenitic Cr-Ni-Mn-Mo stainless steel. It features high resistance to cracking caused by impact and high temperature and is therefore indicated for difficult to weld steels and depositing stress relaxing buffer layers on crack sensitive base metal or beneath hardfacing deposits. Use with DCEP. No pre-heat or post welding heat treatment is needed when welding armour plates. Interpass temperature should not exceed 120°C. Shall be used with shortest possible stick-out distance, at 90° angle to the work piece.

Typical Chemical Values of Weld Metal

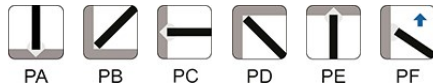
| Type of Analysis | C | Si | Mn | CR | Ni | Mo |
|------------------|------|------|------|-------|-------|------|
| Weld Deposit | 0.08 | 0.55 | 1.80 | 20.00 | 11.50 | 2.50 |

Typical Mechanical Values of Weld Metal

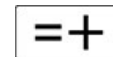
| Test Condition | Yield Strength (N/mm ²) | Tensile Strength (N/mm ²) | Elongation A5 (%) | Charpy V-Notch Properties (J) |
|----------------|-------------------------------------|---------------------------------------|-------------------|-------------------------------|
| As welded | 440 | 690 | 40 | 20°C → 70 |

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

| Diameter x Length (mm) | Current (A) |
|------------------------|-------------|
| 2.50x250 | 50-80 |
| 2.50x300 | 50-80 |
| 3.25x300 | 80-120 |
| 4.00x350 | 100-165 |
| 5.00x350 | 140-220 |

Packaging Information

| Product Code | Diameter x Length (mm) | Quantity per Box | Box Gross Weight (kg) | Boxes per Outer Box | Outer Box Gross Weight (kg) | Packaging Type |
|--------------|------------------------|------------------|-----------------------|---------------------|-----------------------------|----------------|
| 13007GJEM2 | 2.50x300 | 104 pcs | 1.79 | 9 | 16.30 | VAC Box |
| 13007MJEM2 | 3.25x300 | 62 pcs | 1.79 | 9 | 16.30 | VAC Box |
| 13007QJEM2 | 4.00x350 | 46 pcs | 2.04 | 9 | 18.60 | VAC Box |
| 13007TJEM2 | 5.00x350 | 25 pcs | 2.07 | 9 | 18.80 | VAC Box |

Storage & Re-Drying Information

It can be dried maximum 5 times.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.
It has to be dried at 350°C for 2 hours.