

# CLEAROSTA E 304L

## CLASSIFICATION

AWS A5.4	E308L-17	A-Nr	Mat-Nr
ISO 3581-A	E 19 9 L R 22	F-Nr	
		9606 FM	

## TEMPERATURE RANGE

Pressurized parts :  
Oxidation resistance :

## GENERAL DESCRIPTION

Double coated electrode for welding similar austenitic stainless steel  
High operator appeal and control due to the more stable and focused arc transfer  
Reduced welding fume (up to -40%) and lower hexavalent Cr content (up to -60%) of the fume contribute to an improved working environment in the workshop, for all workers  
Suitable for root pass  
Lower porosity, good striking and restriking  
Excellent slag removal  
Available in vacuum pack

## WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G



PH/5Gu

## CURRENT TYPE

DC +

## APPROVALS

CE	TÜV
+	+

## CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni	P	S	FN (acc.WRC 1992)
0.03	0.8	1.00	19.5	10.0	0.025	0.01	5-10

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength	Tensile strength	Elongation	Impact ISO-V(J)
		(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	(%)	+20°C
Typical values	AW	≥420	≥520	≥35	≥50

## PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	2.5	3.2	4.0	5.0
	Length (mm)	300	350	350	350
Vacuum pack	Pieces / unit	90	55	40	20
	Net weight/unit (kg)	1.7	1.9	2.1	1.6

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## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	Mat. Nr
Extra low carbon [C <0.03%]	X2CrNiN18-10	1.4311
Medium carbon [C >0.03%]	X4CrNi18-10	1.4301
Ti-, Nb stabilized	X6CrNiTi18-10	1.4541

## CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Current type	Arc time	Energy	Dep. rate	Weight/ 1000 pcs (kg)	Electrodes/ kg weldmetal	kg electrodes/ kg weldmetal
			(S)*	E(kj)	H(kg/h)		B	1/N
2.5 x 300	70 - 90	DC+	36	-	1.1	-	95	1.76
3.2 x 350	100 - 120	DC+	53	-	1.4	-	48	1.67
4.0 x 350	140 - 160	DC+	59	-	1.9	-	32	1.69
5.0 x 350	190 - 210	DC+	69	-	2.6	-	20	1.65

\*Stub end 35mm

## WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions					
	PA/1G	PB/2F	PC/2G	PF/3Gup	PE/4G	PH/5Gup
2.5	80A	80A	75A	70A	75A	75A
3.2	110A	110A	100A	90A	100A	100A
4.0	150A	150A	130A			
5.0	200A	200A				