AS P-308Mn

Coated Electrode for Stainless Steels

Classification

EN 1600 : E 18 8 Mn B 22
AWS A5.4 : (E307-15)
DIN 8555 : E8 - 200 CKZ
Werkstoff-Nr : 1.4370

General Description

AS P-308Mn is a basic coated electrode. It gives an austenitic filler metal of the Cr-Ni type that is high (6.0 %) in Mn content. Weld beads are highly resistant to oxidation at operating temperatures up to 850°C and also to acids.

Chemical Composition (w%), Typical, All Weld Metal

C	Si	Mn	Cr	Ni
0.10	0.50	6	18	9

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 420 N/mm²
Tensile Strength : 640 N/mm²
Elongation (L=5d) : 35 %
Impact (ISO-V) : 100 J (+20°C)
75 J (–60°C)
Hardness : 200 HB (as welded)
400 HB (after cold working)

Approvals

CE, GOST, SEPRO, TSE, TÜV

GL (4370)

Applications and Materials to be Welded

AS P-308Mn can be used for welding hardenable steels (alloyed or unalloyed), Mn steels, armour plates, rail steels, stainless chromium steels, tool steels and steels with poor weldability. Building up of parts operating under impact, high pressure and cavitation; surface build up of water turbine vanes; build up of valve seats and joining and building up of rail switches are among its usage areas. AS P- 308 Mn can also be used for forming buffer layer passes before hardfacing applications having a chromium carbide structure.

The lowest possible welding current should be selected to avoid the overheating of the electrode during welding. For hard Mn- steels, weld beads should be forged.

	EN 10088-1/-2	W. Nr.	EN 10088-1/-2	W. Nr.
Heat Resistant Stainless Steels	X6 Cr 13	1.4000	X10 CrAlSi 7	1.4713
	X12 Cr 13	1.4006	X10 CrAlSi 13	1.4724
	X20 Cr 13	1.4021		
	X17 CrNi 16 2	1.4057		

Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : DC (+)

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
2.50	250	50 - 80	1590	1.6 / 100	1.5
3.25	300	80 - 110	3030	2.3 / 75	2.0
4.00	350	100 - 140	5100	2.3 / 45	2.5
5.00	350	140 - 160	7060	2.5 / 35	2.5


1G/PA 2F/PB 2G/PC


4G/PE 3G/PF