

Coated Electrode for Stainless Steels

Classification

EN 1600 : E 20 10 3 B 22
 AWS A5.4 : E308 Mo-15
 Werkstoff-Nr : 1.4431

General Information

AS P-308Mo is a basic coated electrode. It gives a filler metal of the Cr-Ni-Mo type that is high (2.5 %) in Mn content. Weld beads are highly resistant to sudden impact and cracking due to heat effect.

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

C	Si	Mn	Cr	Ni	Mo
0.05	0.35	2.5	19	10	2.5

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 420 N/mm²
 Tensile Strength : 620 N/mm²
 Elongation (L=5d) : 38 %
 Impact (ISO-V) : 100 J (+20°C)

Approvals

GOST, SEPRO, TSE

Applications

AS P-308Mo is used for forming a buffer layer for hardfacing and joining of armour steel plates, heat treatable steels, different type steels and for steels with poor weldability.

There is no need to apply heat treatment to armour steel plates before or after the welding. Interpass temperature during welding should not exceed 120°C. It is also used to form a buffer layer for stress relief before hardfacing applications.

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]
3.25	300	80 - 110	2855	2.0 / 70	2.0
4.00	350	110 - 140	5095	2.3 / 45	2.5

