

## Stick electrode

**Features:** ■ Suitable for dissimilar joint between carbon steel and stainless steel rich in carbon or nickel.

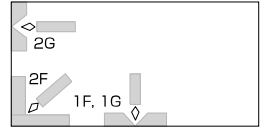
**Classification:** AWS A5.4 E312-16

**Redrying Conditions:** 150~250°Cx0.5-1h

**Identification color:** 1st Green, 2nd Red

**Polarity:** AC, DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	300	2	20	27	300W, 110H, 330L
4.0	350	5	20	49	175W, 120H, 380L
5.0	350	5	20	76	175W, 120H, 380L

## Composition (all-weld metal mass%)

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.13	0.15
<b>Si</b>	0.62	1.00
<b>Mn</b>	1.2	0.5~2.5
<b>P</b>	0.01	0.04
<b>S</b>	<0.01	0.03
<b>Ni</b>	9.6	8.0~10.5
<b>Cr</b>	28.2	28.0~32.0
<b>Mo</b>	0.01	0.75
<b>Cu</b>	0.05	0.75

Note: <sup>a</sup> Single values are maximum.

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G
3.2	70~115
4.0	95~145
5.0	135~180

## All-weld mechanical properties

	Typical (AC)	Guaranty
<b>0.2%YS (MPa)</b>	624	-
<b>TS (MPa)</b>	785	655min.
<b>EI on 4d (%)</b>	20	22min.