

Index of welding consumables

2011.06.10

Covered electrode for stainless steel

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| JIS Standard | Flux type | Trade Name | Diameter (mm φ) | Welding position | Applications | Characteristic on usage | Approved Class | Typical permissible substitute | | | |
|--------------|-------------------|------------|-------------------------|------------------|--|--|----------------|--------------------------------|-------------------|-------------------|--------------------|
| | | | | | | | | KOBE STEEL | TASETO | NSSW | NIPPON WELDING ROD |
| ES308-16 | Lime-titania type | SS-308 | 2.0, 2.6, 3.2, 4.0, 5.0 | All-position | For welding of 18%Cr-8% stainless steel such as SUS304. | This is lime-titania type covered electrode of 18%Cr-8%Ni stainless steel. The organization of 19%Cr-9%Ni is obtained. The arc is stable with little spatter. The usabilities such as slag removal and bead appearance are good. | NK KD308 | NC-38 | RNY308 EN308 | -308•R -308•RX | WEL308 |
| ES308L-16 | Lime-titania type | SS-308L | 2.0, 2.6, 3.2, 4.0, 5.0 | All-position | For welding of low carbon 18%Cr-8% stainless steel such as SUS304L. | This is lime-titania type covered electrode of low carbon 18%Cr-8%Ni stainless steel. The organization of 19%Cr-9%Ni is obtained. The arc is stable with little spatter. The usabilities such as slag removal and bead appearance are good. | - | NC-38L | RNY308L EN308L | -308L•R | WEL308L |
| ES309-16 | Lime-titania type | SS-309 | 2.0, 2.6, 3.2, 4.0, 5.0 | All-position | For welding of 22%Cr-12%Ni stainless steel such as SUS309S. For welding of dissimilar metals such as stainless steel to carbon steel or low alloy steel. | This is lime-titania type covered electrode of 22%Cr-12%Ni stainless steel. The organization of 25%-12%Ni is obtained. The arc is stable with little spatter. The usabilities such as slag removal and bead appearance are good. | NK KD309 | NC-39 | RNY309 EN309 | -309•R -309•RX | WEL309 |
| ES309L-16 | Lime-titania type | SS-309L | 2.0, 2.6, 3.2, 4.0, 5.0 | All-position | For welding of 22%Cr-12%Ni stainless steel such as SUS309S. For under layer welding of the cladded side of SUS304 clad steel. | This is lime-titania type covered electrode of low carbon 22%Cr-12%Ni stainless steel. The organization of 25%-12%Ni is obtained. The arc is stable with little spatter. The usabilities such as slag removal and bead appearance are good. | - | NC-39L | RNY309L EN309L | -309L•R | WEL309L |
| ES309LMo-16 | Lime-titania type | SS-309MoL | 2.0, 2.6, 3.2, 4.0, 5.0 | All-position | Shielded metal arc welding of dissimilar metals such as low carbon 18%Cr-12%Ni-2%Mo stainless steel to mild steel or low alloy steel. Under layer welding of the cladded side groove of SUS304L. | The organization of low carbon 25%Cr-12%Ni-2.5%Mo is obtained. The arc is stable with little spatter. The usabilities such as slag removal and bead appearance are good. There is a HMo type (2.8~3.0%Mo)as special edition. | NK KD309MoL | NC-39MoL | RNY309MoL | -309ML•R | WEL309MoL |
| ES316-16 | Lime-titania type | SS-316 | 2.0, 2.6, 3.2, 4.0, 5.0 | All-position | For welding of 18%Cr-12%-2%Mo stainless steel such as SUS316. | This is lime-titania type covered electrode of 18%Cr-8%Ni-2%Mo stainless steel. The organization of 18%Cr-12%Ni-2.5%Mo is obtained. The arc is stable with little spatter. The usabilities such as slag removal and bead appearance are good. | - | NC-36 | RNY316 EN316 | -316•R | WEL316 |
| ES316L-16 | Lime-titania type | SS-316L | 2.0, 2.6, 3.2, 4.0, 5.0 | All-position | For welding of low carbon 18%Cr-12%-2%Mo stainless steel such as SUS316L. | This is lime-titania type covered electrode of low carbon 18%Cr-8%Ni-2%Mo stainless steel. The organization of 18%Cr-12%Ni-2.5%Mo is obtained. The arc is stable with little spatter. The usabilities such as slag removal and bead appearance are good. There is a HMo type (2.8~3.0%Mo)as special edition. | NK KD316L | NC-36L | RNY316L EN316L | -316L•R | WEL316L |