EZ - KROM 30 R

CLASSIFICATION

EN ISO 3581-A	AWS / ASME SFA-5.4
E 19 12 3 LR 12	E316L-16

DESCRIPTION AND APPLICATION

A low-carbon rutile electrode for welding of identical and similar (stabilized and unstabilized) stainless steels. Weld metal is of austenitic Cr-Ni-Mo type with delta-ferrite. Weld metal is resistant to intergranular corrosion on working temperatures up to 350°C.

Steel grade	HRN	DIN (W. Nr.)	ASTM / AISI	EN / ISO
Stainless high-alloy austenite steels	Č 4573	X5 CrNiMo 17 12 2 (1.4401)	316	X5CrNiMo17-12-2
	Č 45703	X2 CrNiMo 17 13 2 (1.4404)	316 L	X2CrNiMo17-12-2
	Č 4574	X6 CrNiMoTi 17 12 2 (1.4571)	316 Ti	X6CrNiMoTi17-12-2
	Č 4583	X6 CrNiMoNb 17 12 2 (1.4580)	316 Cb	X6CrNiMoNb17-12-2
	ČL 4580	G-X6 CrNiMo 18 10 (1.4408)	-	GX5CrNiMo19-11-2
	ČL 4573	G-X10 CrNiMo 18 9 (1.4410)	-	-

MECHANICAL PROPERTIES OF THE ALL-WELD METAL

$R_{p0,2}$ N/mm²	R_m N/mm²	A_5 %	KV (-20°C) J
> 320	> 510	> 25	> 47

APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

	C	Mn	Si	Cr	Ni	Mo
%	≤ 0,03	0,9	0,8	18,5	12	2,7

RECOMMENDED WELDING CURRENT

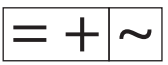
Ø mm	2,0	2,5	3,2	4,0	5,0
A	40 - 60	50 - 85	70 - 125	110 - 165	160 - 230

PACKAGING

Electrode dimensions mm	Quantity per ton approx. pieces	Weight of packaging kg	Weight of transport box pcs x kg/pcs = kg
Ø 2,0 x 300	79 100	1,1	15 x 1,1 = 16,5
Ø 2,5 x 300	52 800	1,1	15 x 1,1 = 16,5
Ø 3,2 x 350	26 300	1,1	17 x 1,1 = 18,7
Ø 4,0 x 350	18 200	1,2	16 x 1,2 = 19,2
Ø 5,0 x 450	9 100	6,0	5 x 6,0 = 30,0

APPROVALS

ABS (316 L-16); BV (UP); DB; DNV (316 L); LR (316 L); RS (A-6); TÜV



Marking: **EZ - KROM 30 R**
Dry before use 2h/300°C