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|---|------------------------------|-------------|
|  | TECHNICAL DESCRIPTION | FT-DT.14.08 |
| | EUROTROD LC 21 | PAGE 42/42 |

CERTIFIED COMPANY:

| | | | |
|---|---|--|---|
|  |  | <small>APCER CERTIFICADO N. 2000/CEP. 1272 SISTEMA PORTUGUÊS DA QUALIDADE NF EN ISO 9001</small> |  |
|---|---|--|---|

CLASSIFICATION:

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| AWS A5.4: E 308L-16 EN 1600: E 19 9 LR 12 |
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DESCRIPTION:

Rutile high-alloy extra-low carbon electrode (ELC) for non-stabilized and stabilized chromium-nickel steels 18 Cr/10 Ni type with Titanium or Niobium. Excellent welding (AC/DC), smooth running. Good striking and restriking. Regular appearance, finely rippled, smooth junction. Easy slag removal.

SUITABLE FOR:

| | | | |
|----------------------------------|---------------------|--|--|
| AISI 302, 304, 304 L, 308, 308 L | AISI 321, 347 | | |
| W Nr 1.4541, 1.4550, 1.4552 | W Nr 1.4306, 1.4311 | | |
| W Nr 1.4301, 1.4303, 1.4308 | W Nr 1.4310, 1.4319 | | |

TYPICAL CHARACTERISTICS OF ALL-WELD METAL:

Chemical Analysis (%):

| C | Si | Mn | Cr | Ni | | | |
|--------|------|------|-------|-------|--|--|--|
| < 0,03 | 0,75 | 0,55 | 18,50 | 10,50 | | | |

Mechanical Properties:


| Yield Strength (N/mm ²) | Tensile Strength (N/mm ²) | Elongation 5d (%) | | |
|--|--|----------------------|--|--|
| >350 | >520 | >35 | | |

PRODUCT INFORMATION:

| WELDING PARAMETERS | | | | VACUUM PACKING | |
|--------------------|----------------|----------------------------|--------------------------|------------------------|------------------------|
| Diameter (mm) | Length (mm) | Recommended Current (A) | Current Type (Pole +) | Pieces /Packet (Un) | Weight /Packet (kg) |
| 1,6 | 300 | 25 – 30 | AC/DC | 210 | 1,6 |
| 2,0 | 300 | 30 – 50 | AC/DC | 145 | 1,8 |
| 2,5 | 300 | 50 – 75 | AC/DC | 100 | 1,8 |
| 3,2 | 350 | 75 – 110 | AC/DC | 55 | 2,0 |
| 4,0 | 350 | 110 – 150 | AC/DC | 35 | 2,0 |
| 4,0 | 450 | 110 – 150 | AC/DC | 80 | 5,5 |

APPROVALS:

- I.S.Q. (Welding Institute of Quality): Cert. Nº 09/1299
- Bureau Veritas / Rinave: Cert. Nº 09.L.2452

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|  1328 08 1328-CPD-0113 EN 13479 + EN 1600 - E 19 9 L R |
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WELDING POSITIONS:

