

EZ - KROM 10 R

CLASSIFICATION

EN ISO 3581-A	AWS / ASME SFA-5.4
E 19 9 LR 12	E308L-16

DESCRIPTION AND APPLICATION

A low-carbon rutile electrode for welding of identical or similar (stabilized and unstabilized) stainless steels. Weld metal is of austenitic Cr-Ni type with delta-ferrite.

Weld 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 4580	X5 CrNi 18 11 (1.4301)	304	X5CrNi18-10
	ČL 4571	G-X 10 CrNi 18 8 (1.4312)	-	GX10CrNi18-8
	Č 45701	X2 CrNi 19 11 (1.4306)	304 L	X2CrNi19-11
	ČL 45701	G-X6 CrNi 18 9 (1.4308)	-	GX5CrNi19-10
	Č 4582	X6 CrNiNb 18 10 (1.4550)	347	X6CrNiNb18-10
	ČL 4572	G-X5 CrNiNb 18 9 (1.4552)	-	GX5CrNiNb19-11
	Č 4572	X6 CrNiTi 18 10 (1.4541)	321	X6CrNiTi18-10

MECHANICAL PROPERTIES OF THE ALL-WELD METAL

R _{p0.2} N/mm ²	R _m N/mm ²	A ₅ %	KV (-20°C) J
> 320	> 510	> 30	> 47

APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

	C	Mn	Si	Cr	Ni
%	≤ 0,03	0,9	0,9	19	10

RECOMMENDED WELDING CURRENT

Ø mm	2,0	2,5	3,2	4,0	5,0
A	20 - 60	50 - 85	70 - 125	110 - 165	160 - 230

PACKAGING

Electrode dimensions mm	Quantity per ton approx. pieces	Weight of packaging kg
Ø 2,0 x 300	82 700	1,1
Ø 2,5 x 300	52 800	1,1
Ø 3,2 x 350	26 300	1,1
Ø 4,0 x 350	18,200	1,2
Ø 5,0 x 450	9 100	6,0

APPROVALS

ABS (308 L-16); BV (UP); DB; DNV (308 L); LR (304L); TÜV



Marking: **EZ - KROM 10 R**
Dry before use 2h/300°C