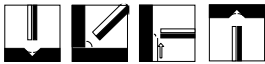


<b>NSN-308Mo</b>	<b>FOR WELDING 19Cr-10Ni-2.5Mo AUSTENITIC STAINLESS STEELS</b>				<b>DATA SHEET NO. 60B</b>						
SPECIFICATION	AWS A5.4		EN ISO 3581-A								
CLASSIFICATION	E308Mo-16		E 20 10 3 R								
PRODUCT DESCRIPTION	<p>A metallurgically advanced rutile based flux formulated with balanced additions of chemically basic, amphoteric and acid minerals, together with small alloy additions to compensate for arc losses.</p> <p>The flux is concentrically extruded onto a fully alloyed core wire and bound by a blend of silicates that assures both coating strength and resistance to subsequent moisture absorption.</p>										
WELDING FEATURES OF THE ELECTRODE	<p>This unique flux formulation ensures excellent arc stability, ease of initial arc strike and re-strike minimal spatter on AC and virtually none on DC+. The resultant weld seams are smooth, evenly rippled and free from undercut while slag detachability is excellent. Metal recovery is some 103% with respect to core wire weight.</p>										
APPLICATIONS AND MATERIALS TO BE WELDED	<p>These electrodes are the same as NSN-308, except for the addition of molybdenum. NSN-308Mo electrodes are recommended for welding ASTM CF8M stainless steel castings, as they match the base metal with regard to chromium, nickel, and molybdenum. They may also be used for welding wrought materials such as Type 316 stainless when increased ferrite is desired beyond that attainable with E316 electrodes.</p>										
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe
	Min.	-	0.5	-	-	-	18	9.0	2.0	-	
	Max.	0.08	2.5	1.0	0.03	0.04	21	12	3.0	0.75	
	Typical	0.01	1.3	0.5	0.01	0.03	18.5	10	2.5	0.1	Bal.
WELD METAL PROPERTIES (ALL WELD METAL)	PROPERTY	UNITS	MINIMUM	TYPICAL	OTHERS						
	Tensile strength	N/mm <sup>2</sup>	550	650							
	0.2% Proof stress	N/mm <sup>2</sup>	-	450							
	Elongation on 4d	%	30	50							
	Reduction of Area (RA)	%	-	40							
	Impact energy 20 °C	J	-	60							
WELDING AMPERAGE AC or DC+	Ø x Length (mm)	2.6 x 300	3.2 x 350	4.0 x 350							
	Min.	65	75	120							
	Max.	100	125	170							
OTHER DATA	Electrodes that have become damp should be re-dried at 150°C for 1 hour										
RELATED PRODUCTS	Please contact our Technical Department for detail.										