Classification:

EN 1600:	E 19 9 LR 12
DIN 8556 :	E 19.9 LR 26
AWS A-5.4:	E 308L-17
EN ISO 3581-A:	E 19 9 LR 12
W.Nr.:	1.4316

elektrode jesenice d.o.o.

INOX R 19/9 NC

Description and application:

Austenitic rutile, low carbon electrode for welding nonstabilised and stabilised stainless steels. Resistant to intergranular corrosion up to 350°C, resistant to oxidation up to 800°C and good low-temperature ductility down to temperature –196°C.

Base materials:

	DIN:	W.Nr.:	AISI/ASTM:
Chemical corr.resistant steel:	X 5 CrNi 18 10	1.4301	304
	X 2 CrNi 19 11	1.4306	304 L
	X 6 CrNiTi 18 10	1.4541	321
	X 6 CrNiNb 18 10	1.4550	347
Alloyed steel castings:	G-X 6CrNi 18 9	1.4308	-
	G-X 5 CrNiNb 18.9	1.4552	-

Coating type:

Rutile

Welding current:

AC
DC +

Welding positions:

Redrying temperature:

300°C / 2h

Ferrite content: FN ≈ 5

Typical all weld metal properties:

Chemical composition, wt %:

C	Si	Mn	Cr	Ni
≤ 0.03	0.8	0.7	19	10

Mechanical properties:

Yield strength	R_{eL} / $Rp_{0.2}$:	> 340	MPa(N/mm^2)
Tensile strength	Rm:	> 540 – 640	MPa(N/mm^2)
Elongation	A5:	> 35	%
Impact energy	KV :	> 47 J (+20°C) typical: 70J > 32 J (-196°C)	

Welding and packing data:

Approvals:

BV: UP
DNV: 308L
RS: 308L
TÜV
DB
CR
SŽ

Welding parameters			Packing		
ϕ mm	Length mm	Current A	Weight/ packet kg	Weight/ carton kg	Weight/ 1000 pcs kg *
2	250/300	30 – 50	3.5/3.8	14/15.2	
2.5	300	50 – 85	3.8	15.2	18.1
3.25	350	70 – 125	4.5	18	35.4
4	350	110 – 165	4.5	18	53.6
5	350	165 - 230	4.5	18	81.8

* approximate data