

ESAB 304B



An extra low carbon, basic type 19/9 stainless steel electrode



Classification AWS A5.4: E 308L-15
 IS 5206: E 19.9LB 20
 DIN 8556: E 19 9 LB 20

DESCRIPTION

ESAB 304B is an extra low carbon, basic covered stainless steel electrode with outstanding welding properties in the vertical and overhead position. The weldmetal is highly resistant to cracking and porosity and has good impact toughness at very low temperatures. The low percent C prevents intergranular corrosion in the temperature range 425°C and 823°C. The slag system allows excellent welding characteristics in all positions, slag cover that is easily detachable, and a weldbead that is shiny and finely rippled. The weldmetal has excellent creep strength and is of radiographic quality.

WELDING CURRENT: DC +

TYPICAL APPLICATIONS

ESAB 304B is mainly used for welding stainless steels having a corresponding chemistry with high ductility and high impact values at low temperature cryogenic applications (-196°C working temperatures). Stainless steel conforming to grades AISI 301, 302, 304, 304L, 304 having very low carbon contents, BS: EN 58, 58A, 58E etc. are some of the steels which are widely fabricated with ESAB 304B and they find extensive use in food and beverage industries, chemical and petrochemical industries etc.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	< 0.03	Mn	2.00	YS	420 N/mm ²
Cr	19.0	S	0.015	UTS	570 N/mm ²
Si	0.40	P	0.018	EL (L=4d)	45%
Ni	10.50			Impact(CVN) at - 196°C	40J

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	40-60	80	400
3.15	350	60-90	65	325
4.00	350	85-130	40	200
5.00	350	140-180	30	150

PACKING: Electrodes are packed in heat sealed plastic cartons and five of these cartons are shrink wrapped in a cardboard box.