

ESAB 304B

ESAB 304B is a low carbon, basic coated 19Cr-10Ni stainless steel electrode with outstanding welding properties in the vertical and overhead positions. The weld metal is highly resistant to cracking & porosity and has good impact toughness at very low temperatures.

Specifications

| | |
|------------------------|---|
| Classifications | EN ISO 3581-A : E 19 9 L B 2 2 SFA/AWS A5.4 : E308L-15 |
|------------------------|---|

| | |
|------------------------|------------------|
| Welding Current | DC+ |
| Ferrite Content | 2-8 FN |
| Alloy Type | Austenitic Cr-Ni |
| Coating Type | Basic |

Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|------------|----------------|------------------|------------|
| AWS | | | |
| As Welded | 450 MPa | 570 MPa | 40 % |

Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|------------|---------------------|--------------|
| AWS | | |
| As Welded | -196 °C | 30 J |

Typical Weld Metal Analysis %

| C | Mn | Si | Ni | Cr |
|------|------|------|-------|-------|
| 0.03 | 1.50 | 0.40 | 10.50 | 19.00 |

Deposition Data

| Diameter | Current |
|---------------|-----------|
| 4.0 x 350 mm | 120-170 A |
| 2.5 x 350 mm | 60-100 A |
| 3.15 x 350 mm | 80-120 A |