

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