

## M-90 E316

### FEATURES

- \*GOOD RESISTANCE TO CORROSION AND OXIDIZING ENVIRONMENTS
- \*GOOD HEAT RESISTANCE
- \*ASY TO REMOVE SLAG
- \*LOW SPATTER

### APPLICATION

- \*HIGH RECOVERY (170%) RUTILE COATED ELECTRODE FOR WELDING AUSTENITIC STAINLESS CR-NI-MO STEELS
- \*USED WHENEVER EASY WELDING, SMOOTH WELDING SURFACES AND A HIGH DEPOSITION RATES ARE REQUIRED

### CLASSIFICATION

\*A5.4/ ASME SFA5.4 E316-16

### CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Ni	MO
0.03	0.77	0.9	0.03	0.029	18.7	12.3	2.5

### MECHANICAL PROPERTIES

T.S	EL
N/mm2 (lbs/in 2 )	(%)
572 (83,100)	40.8

### WELDING PARAMETERS

DIAMETER (mm)	2.5	3.2
LENGTH (mm)	350	350
CURRENT (amps)	50-85	70-100

### CURRENT

\*AC or DC +-

### WELDING POSITIONS

