

## GENERAL DESCRIPTION

Elite 741 is a Rutile coated, low carbon grade electrode for the high-quality welding of austenitic stainless steel of the 19 Cr / 10 Ni type. with controlled ferrite approx. 6-8% for maximum resistance to cracking and corrosion

- Excellent weldability stable arc
- Soft start and Re-strike
- Exceptional weld bead appearance,
- Minimal Splatter
- Easy slag removal
- All positional Rutile Type (except vertical down)
- Vacuum packed

## WELDING POSITIONS



## CLASSIFICATION

AS/NZS 4854 B-ES308L-16

ISO 3581-A - E 19 9 LR 32

AWS A5.4 :E308L-16

## CHEMICAL COMPOSITION

| Wt% - wire | Si   | C    | Mn   | Cr | Ni   | Mo   | S     | P     |
|------------|------|------|------|----|------|------|-------|-------|
|            | 0.90 | 0.03 | 0.80 | 19 | 9.50 | 0.10 | 0.010 | 0.025 |

## TYPICAL MECHANICAL PROPERTIES

| Typical as welded                |         |
|----------------------------------|---------|
| Tensile strength                 | 610 MPa |
| Elongation A5 (%)                | 38%     |
| Charpy Impact Value (ISO-V J RT) | 60      |

## DEPOSITION DATA – AC / DC (+)

|             | 2.5mm                                               | 3.2mm   |
|-------------|-----------------------------------------------------|---------|
| Current (A) | 50-80A                                              | 70-100A |
| Voltage (V) | Determined by arc current and electrode arc length. |         |

Welding parameters are a guide only as they are dependent on the machine used, material thickness and operator experience.  
No data is to be construed as a recommendation for any welding condition or technique by Euromarc.

## CONFORMANCE AND APPROVAL

CE  
LR  
TUV  
DB

## REBAKING

Re-baking is not necessary if the package is intact.  
If necessary redry electrodes at 300-350°C for 1hr.  
Interpass temperature :< 200°C.

## STORAGE

Store open packets in a heated cabinet.

## WARNING

Electric shock can kill. Arc rays can injure eyes. Welding fumes are hazardous to your health and may damage lungs and other organs. Use adequate ventilation. Arc rays and sparks can injure eyes and burn skin. Wear correct hand, head, eye and body protection.

Read and understand the Safety Data Sheet for this product.

## PACKAGING INFORMATION

| Size  | Weight | Length | Vacuumed Packed | Part Number / Order code |
|-------|--------|--------|-----------------|--------------------------|
| 2.5mm | 2kg    | 350mm  | Yes             | VE74125302               |
| 3.2mm | 2kg    | 350mm  | Yes             | VE74132305               |

