

GENERAL DESCRIPTION

Elite 745 is a Rutile coated low carbon stainless steel electrode for welding stainless steel containing 22 - 25% Cr and 12 - 14% Ni. dissimilar steels (austenitic to ferritic steels)

- Excellent weldability stable arc
- High Crack Resistance
- Stainless Steel to Dissimilar Steel
- Suitable for dissimilar carbon manganese steels and low alloy steels.
- Welding of stainless steels to mild steels and as a buffer for hardfacing applications.
- Suitable for buffer layer on clad steels chromium nickel alloys like 18/8
- All positional Rutile Type
- Vacuum packed

WELDING POSITIONS



CLASSIFICATION

AS/NZS 4854 B-ES309L-16

EN ISO E 23 12 L 26

AWS: A5.4 E309L-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	600 MPa
Elongation A5 (%)	35%
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	VE74525302
3.2mm	2kg	350mm	Yes	VE74532305

