

EF-300N

For stainless steel and duplex stainless steel

Classifications

- Sub-arc flux
EN ISO 14174 - 2012 : SA AF 2 DC

Description

- Agglomerated basic welding flux for welding stainless high alloyed CrNi(Mo) steels
- Excellent impact value at low temperature down to -196°C
- The weld metals show good mechanical properties
- Excellent weldability such as stable arc and easy slag removal
- Redry the flux at 250~350°... for 60 minutes before use
- Add new flux periodically when continuously reusing the flux
- Excessive flux height may bring out poor bead appearance

Typical chemical composition of all-weld metal (%)

Wire	C	Si	Mn	Cr	Ni	Mo	N
M-308L	0.02	0.6	1.5	19.4	9.6	—	—
M-309L	0.02	0.5	1.6	23.0	13.5	—	—
M-316L	0.02	0.6	1.3	18.6	11.6	2.4	—
M-2209	0.02	0.5	1.2	22.5	8.5	3.1	0.5

Typical mechanical properties of all-weld metal

Wire	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-60°C	-196°C	
M-308L	390	560	42	90	60	AW
M-309L	430	580	36	100	80	AW
M-316L	410	570	39	100	80	AW
M-2209	650	800	35	70	—	AW

* AW : As-Welded