

SATINCROME 308L-17



- ▲ Rutile Type, Stainless Steel Electrode.
- ▲ Outstanding Operator Appeal!
- ▲ Now with Improved Slag Lift!
- ▲ All Positional (except vertical down) Welding Capabilities.
- ▲ Advanced Moisture Resistant Flux Coating.

Classifications:

AS/NZS 1553.3: E308L-17.
 AWS/ASME-SFA A5.4: E308L-17.

Description and Applications:

Satincrome 308L-17 is a smooth running, rutile type stainless steel electrode manufactured by CIGWELD for the all positional (except vertical-down) fillet and butt welding of 19Cr/10Ni type stainless steels.

The features of Satincrome 308L-17 include high AC arc stability, sound radiographic quality, smooth arc transfer characteristics, very low spatter levels and excellent bead shape and contour. The advanced moisture resistant (MR) flux coating provides improved resistance to start-of-run porosity. Slag lift of Satincrome 308L-17 is enhanced in all welding positions, it is self peeling and non-spitting.

Applications of Satincrome 308L-17 include the single and multi-pass welding of 19Cr/10Ni type stainless steel grades including 201, 202, 301, 302, 303, 304, 304L, 305, 308 etc.

COMPARABLE CIGWELD PRODUCTS:

Autocraft 308LSi GMAW wire
 AWS A5.9: ER308LSi.
 Comweld 308L Gas/TIG wire
 AWS A5.9: ER308L.
 Shieldcrome 308LT & FCAW wires
 AWS A5.22: E308LT1-1/4

APPROVALS:

American Bureau of Shipping AWS A5.4: E308L-17.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

0.2% Proof Stress	500 MPa
Tensile Strength	630 MPa
Elongation	40%
CVN Impact Values	75J av @ +20°C.

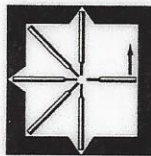
TYPICAL ALL WELD METAL ANALYSIS:

C: 0.025%	Mn: 0.76%	Si: 0.87%
Cr: 20.4%	Ni: 9.8%	S: 0.010%
P: 0.017%		

FERRITE NUMBER:

3.0 - 10.0 FN*

* - using Severn Gauge



All positional - except vertical down

Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	300	47	40-70	2.5kg	15kg - 6 x 2.5kg	611602
3.2	350	28	75-110	2.5kg	15kg - 6 x 2.5kg	611603
4.0	350	18	110-150	2.5kg	15kg - 6 x 2.5kg	611604

CASTCRAFT 100

45 OCV AC DG+

- ▲ Maintenance Welding of Cast Irons.
- ▲ Lime Fluorspar / Graphite Coating.
- ▲ Soft, Ductile Nickel Deposit.
- ▲ Easy starting and Stable Running on Portable 240V Welding Machines.
- ▲ Smoother Weld Deposit Surface Finish.

CORE WIRE:

Nickel (98% Ni)

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Tensile Strength 400 MPa
Hardness 170 HV₃₀

TYPICAL ALL WELD METAL ANALYSIS:

C: 1.0% Mn: 0.05% Fe: 0.5%
Si: 0.1% Al: 0.2% Ni: Bal

Classifications:

AWS/ASME-SFA A5.15: ENI-CI.

Description and Applications:

Castcraft 100 is a basic, graphite coated electrode manufactured by CIGWELD for the repair and maintenance of a wide range of cast iron components.



All downhand welding

It produces a soft stable arc with minimal penetration and spatter and is very tolerant to parent metal contaminants such as oil and dirt. The ductile Nickel based weld deposit is readily machinable with good colour match to most cast irons.

Applications of Castcraft 100 include the repair and reclamation of engine blocks, cylinder heads, differential housings, gear boxes, pump and machine housings and cast iron pulleys etc. In some applications Castcraft 100 is preferred to Castcraft 55 because of the better 'wetting' action of the high nickel weld deposit.

Procedure for Welding Oil Contaminated Cast Iron:

For welding oil impregnated cast iron an increased arc length of up to = 6mm is recommended to reduce the porosity in the weld deposit (caused by the oil) to an acceptable level. For heavy oil contamination, preheating the cast iron up to 200°C will also help to reduce porosity levels.

Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC- polarity.

Electrode Size mm	Electrode Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Easyweld Handipaks	Part No
2.5	300	49	55-85	2.5kg	15kg - 6 x 2.5kg		611732
						20 rod	322110
3.2	350	31	75-120	2.5kg	15kg - 6 x 2.5kg		611733
						15 rod	322111

Easyweld Blister Pack:

10 x 2.5mm/5 x 3.2mm rod Castcraft 100 Blister Pack 322217

WELDALL



- ▲ Easy-to-Use Rutile Type, High Alloy Electrode.
- ▲ Outstanding Operator Appeal!
- ▲ WELDS ALL Steels!
- ▲ Ideal for Repair & Maintenance Jobs.
- ▲ Easy Arc Starting and Excellent Stability on Low O.C.V. Welding Machines.
- ▲ Not Recommended for Welding Cast Irons.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

0.2% Proof Stress	630 MPa
Tensile Strength	780 MPa
Elongation	25%
CVN Impact Values	30 J av @ +20°C.

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.11%	Mn: 0.60%	Si: 0.88%
Cr: 27.0%	Ni: 9.10%	S: 0.011%
P: 0.020%		

Classifications:

AS/NZS 1553.3	E312-17.
AWS/ASME-SFA A5.4:	E312-17.

Description and Applications:

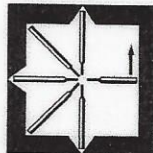
WELDALL is a highly alloyed stainless steel electrode which deposits a strong and ductile duplex austenite-ferrite weld metal extremely resistant to cracking.

WELDALL has a host of features which make it suitable for the welding of all types of steels. These include:

- ◆ Easy arc starting and excellent stability on low Open Circuit Voltage (O.C.V) welding machines such as the CIGWELD Easywelder EC.
- ◆ Rutile type flux coating gives smooth, stable running in all positions (except vertical down) especially on low current settings.
- ◆ High ferrite (= 40%) austenitic stainless steel deposit gives excellent resistance to hot cracking, even when diluted with carbon, austenitic and high alloy steels.
- ◆ Weld deposit gives excellent resistance to corrosion and oxidation.

WELDALL is recommended for the repair and maintenance of all steels, particularly those of unknown composition. It is suitable for:

- ◆ Joining dissimilar steels, such as stainless steel to carbon steel.
- ◆ Repairing die or tool steels.
- ◆ Use as a protective overlay against corrosion.
- ◆ Use as an intermediate or buffer layer prior to hard surfacing.



All positional - except vertical down

Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ polarity.							
Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Easyweld Handipaks	Part No
2.5	300	57	40-80	2.5kg	15kg - 6 x 2.5kg		611702
						20 rod	322101
3.2	350	30	75-110	2.5kg	15kg - 6 x 2.5kg		611703
						15 rod	322102
4.0	350	20	110-150	2.5kg	15kg - 6 x 2.5kg		611704
Easyweld Blister Pack:							
10 x 2.5mm/5 x 3.2mm rod Weldall Blister Pack							322216