



Cromarod 383

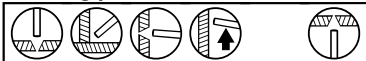
SMAW - (Stick) - MMA
Stainless Steel

Date: 2009-02-27
Revision: 10

Description:

Cromarod 383 is a rutile flux coated electrode specially designed for high alloyed fully austenitic stainless steels of similar composition e.g. Sandvik Sanicro 28. It deposits a 27%Cr / 31%Ni / 3.5%Mo / 1%Cu weld metal with exceptionally good corrosion resistance in non-oxidising acid environments, e.g. sulphuric and phosphoric. With a PRE of approximately 40, the electrode has even higher resistance to pitting corrosion than Cromarod 385.

Welding positions:



Coating type:

Rutile

Welding current:

DC +, AC 0CV > 39V

Ferrite content:

FN 0 (WRC-92)

Redrying temperature:

350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0,5			26,0	30,0
Typical	0,025	0,9	1,0	0,01	0,01	27,5	31,5
Max	0,035	1,0	2,5	0,02	0,02	29,0	33,0

	Mo	Cu	V	Nb
Min	3,2	0,6		
Typical	3,8	1,0		
Max	4,5	1,5	0,1	0,1

Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	400 MPa
Tensile Strength, Rm:	≥ 520 MPa	600 MPa
Elongation, A5	≥ 30%	35%
Impact energy, CV:		20 °C • 55 J

Classification:

EN 1600	E 27 31 4 Cu L R 12
AWS A5.4	~E383-17
ISO 3581-A	E 27 31 4 Cu L R 12

Approvals:

CE

Note

AWS: Slight deviation in C and Si

Core wire:

P ≤ 0.015%

S ≤ 0.010%

N ≤ 0.08%

Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,0	300	74642000	25-50	21	0,64	140	0,50	42
2,5	300	74642500	45-75	21	0,60	88	0,6	56
3,2	350	74643200	70-110	22	0,63	44	1,0	71
4,0	350	74644000	30-170	25	0,64	29	1,9	56