



Zerock E22L

Stainless Steel Electrode

◆ **Description:**

Titania stainless steel welding electrode with low carbon content. Primarily used for welding of Cr 20 – Ni 10 steels with good looking welding seam, outstanding crack resistance and stable electric arc. The welding electrode will have more excellent corrosion resistance and used for elevated strength and oxidation resistance for typical applications arising in the power generator industry.

◆ **Applications:**

Welding of extra low carbon Cr 20.0 Ni 10.0 stainless steel.

◆ **Classification:**

AWS E308L-16

◆ **Typical Chemical Composition of Deposited Metal (%):**

<u>C</u>	<u>Mn</u>	<u>Si</u>	<u>S</u>	<u>P</u>	<u>Cr</u>	<u>Ni</u>	<u>Mo</u>	<u>Cu</u>
0.031	1.17	0.66	0.005	0.025	19.88	9.54	0.04	0.025

◆ **Mechanical Properties of Deposited Metal:**

Tensile Strength	600 Mpa
Elongation	40%
Hardness	20HRC

◆ **Type of Current:**

AC or DC

◆ **Amperages Setting:**

2.5mm	60 – 80
3.2mm	90 - 110
4.0mm	120 – 150