



Zerock E33L Stainless Steel Electrode

◆ **Description:**

Problem steel welding electrode excellent for buffer layer on mild steels and used on clad plate applications extensively. Primarily designed for fabrication applications where tolerance to dilution is exploited in joining 410, 304, 312, 316 to mild and low alloy steels. Suitable for corrosion, crack resistance and high temperature stainless steel.

◆ **Applications:**

Welding of stainless steels to carbon and low alloy steels such as synthetic fiber, petrochemical equipment and nuclear reactor, problem steel.

◆ **Classification:**

AWS E309L-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>
0.03	1.90	0.68	0.015	0.026	23.98	12.43	0.06	0.03

◆ **Mechanical Properties of Deposited Metal:**

Tensile Strength	640 Mpa
Elongation	35%
Hardness	21HRC

◆ **Type of Current:**

AC or DC

◆ **Amperages Setting:**

2.5mm	70 – 90
3.2mm	100 - 130
4.0mm	130 – 160