

Clearosta® E 304L

TOP FEATURES

- Suitable for root pass
- Lower porosity, good striking and restriking
- Excellent slag removal

CLASSIFICATION

AWS A5.4 E308L-17
EN ISO 3581-A E 19 9 L R 22

CURRENT TYPE

DC+

WELDING POSITIONS

Flat/Horizontal

APPROVALS

DNV	TÜV
+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni	P	S	FN (acc.WRC 1992)
0.03	0.8	1.00	19.5	10.0	0.025	0.01	5-10

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
Typical values	AW	≥420	≥520	≥35	≥50

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	70-90
3.2 x 350	100-120
4.0 x 350	140-160
5.0 x 350	190-210

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5x300	VPMD	90	1.7	710001
3.2x350	VPMD	55	1.9	710002
4.0x350	VPMD	40	2.1	710003
5.0x350	VPMD	20	1.6	710004

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.