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WIRES

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BSRM

SHINEFIX

STAINLESS STEEL ELECTRODE

Radiographic
Weld Quality





SHINEFIX

E 308L-16

Extra low-carbon stainless steel electrode for joining 19/10 type stainless steel

Typical Chemical Composition of Weld Metal (%)

C	Mn	Si	Cr	Ni	S	P
0.03	1.2	0.5	19.5	10.0	0.02	0.02

Typical Mechanical Properties:

Condition	UTS (Mpa)	EL%
As welded	590	37

Salient Features

- Rutile based coating
- Controlled ferrite content for maximum cracking resistance
- Extra low-carbon 19/10 type austenitic SS weld
- Smooth operating characteristics
- All position capability
- Resistance to corrosion and scaling up to 800°C
- Radiographic weld quality

Correct Operating Parameters: AC/DC (OCV 50 V min)

Operating & Packing Information:

Dia (mm)	Length (mm)	Weight Per Package (KG)	Proposed Current Range (A)
2.5	300/350	1	50-75
3.20	350	2	80-100
4.0	350	2	110-140

Storage Instructions

Keep the electrodes in a dry place. Preheat at (250-300)°C for 60 minutes before use.

Applications

- Welding Cr-Ni steels represented by AISI 301, 302, 304,304L, 308 , 308L
- Fabrication of boilers, reactors and turbines
- SS piping in refineries, oil and gas industries, chemical plants etc.
- Build up application on SS surfaces of centrifugal pump impellers and shafts, valve faces, seats etc.



Stainless Steel Pipe Welding



Stainless Steel Fabrication



Stainless Steel Staircase