SUPRANOX RS 308Mo

MMA Electrodes
Stainless and Heat resistant steels

SUPRANOX RS 308Mo is a rutile-basic MMA electrode depositing austenitic-ferritic weld metal which is highly resistant to cracking and well-established and approved for armour welding.
Applications include tanks, other military and security vehicles, general engineering components. Particularly suitable for the welding of dissimilar steels (i.e. stainless steel to mild steel) where heat treatment are applicable. It is suitable as buffer layer prior to hardfacing with high alloy weld metals such as chromium carbide types.
Excellent weldability with a spatter free arc, self-releasing slag combined with a very smooth bead appearnace.

Semi-basic electrode with austenitic-ferritic deposit with high resistance to cracking.

Classification	
EN ISO	3581-A: E Z (20 10 3) R 12
AWS	A5.4:~E 308Mo-16

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Ferrite
0.02	0.9	0.8	≤ 0.03	≤ 0.02	19	10	3	5-20

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				20 °C
As Welded	≥ 580	680 - 780	≥ 26	≥ 60

Materials

Dissimilar joints

Storage

Keep dry and avoid condensation.
Re-drying not generally required.
If necessary:250-300°C for 1 hour, 5 times max.

Current condition and welding position

DC+

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	VPMD	
				PC	Code
2.5	300	45-75	18.85	90	W000380169
3.2	350	60-120	35.80	55	W000380156
4.0	350	90-140	52.25	40	W000380157
5.0	350	130-180	84.80	20	W000380838