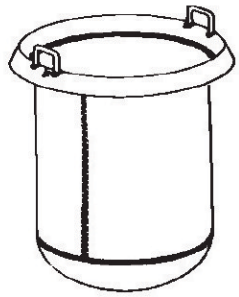
MAGNUM M390

General purpose stainless steel electrode designed for ease of use on types 304L, 301, 302, 303, and 321

Plus a wide range of stainless steel-production rodes



- ❒ **Controlled silicon content provides maximum corrosion/ cracking resistance.**
- ❒ **"Low hydrogen" manufacturing technology ensures high resistance to weld metal porosity.**
- ❒ **High purity core wire gives very low carbon content.**

INTERNATIONAL SPECIFICATIONS		
	AWS/ASME A 5.4: E 308L-16	EN 1600: E 19 9 L R 3 2
	DIN 8556: E19.9LR 26	ISO 3581 E19.9 L R 26
	NFA 81-343: EZ 19.9 LR 26	BS 2926 - 1984 19.9L R

APPLICATIONS:

Use on typical brewery, food, and pharmaceutical equipment, also for architectural fabrication.

MICROSTRUCTURE:

Austenite with 3-9% ferrite. Typical ferrite number is 6.

ALL WELD METAL ANALYSIS (Typical Weight %):

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe
.02	.8	.6	.01	.02	19.5	10	.02	.05	bal

FLUX COLOR: White-Grey

TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	**Maximum Value Up to:**
Tensile Strength	79,500 PSI (530 N/mm^2)
Yield Strength	59,000 PSI (370 N/mm^2)
Elongation	38%
Impact Energy	35J: -157°F (-105°C)
Hardness	Brinell 205, Rockwell B94

RECOMMENDED CURRENT: DC Reverse (+) or AC

RECOMMENDED AMPERAGE SETTINGS:

Diameter (mm)	1/16 (1.6)	5/64(2.0)	3/32 (2.5)	1/8(3.25)	5/32 (4.0)
Minimum Amperage	25	30	55	75	90
Maximum Amperage	35	50	75	110	140

WELDING POSITIONS: Flat, Horizontal, Vertical up, Overhead

DEPOSITION RATES:

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Setting	Recovery Rate
1/16 (1.6)	10" (250)	.13oz (3.6g)	125 (275)	55 (121)	30	100%
5/64 (2.0)	12" (300)	.14oz (4g)	114 (251)	47 (103)	40	100%
3/32 (2.5)	12" (300)	.3oz (9g)	50 (109)	35 (76)	65	100%
1/8 (3.25)	14" (350)	.7oz (20g)	22 (49)	21 (46)	95	100%
5/32 (4.0)	14" (350)	1oz (29g)	15 (33)	18 (40)	120	100%

WELDING TECHNIQUES:

Material to be welded should be clean of all contaminants. Maintain a short arc and use stringer beads rather than a weave technique.