



AUSTOMANG 219

STAINLESS STEEL (Austenitic Manganese Steel)

AWS A/SFA 5.4 **E219-16**

CLASSIFICATION:

ISO 3581-B
ES219-16

KEY FEATURES:

- Rutile type electrode
- High strength, toughness and cracking resistance
- Smooth arc characteristics
- Easy slag removal
- Nitrogen strengthened austenitic stainless steel alloy
- All position welding capability
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of AISI Type 219 (UNS S21900) base metals
- Joining dissimilar alloys like mild steel and the stainless steels
- Direct overlay on mild steel for corrosion applications
- Equipments used at high temperature applications



TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	N
0.05	9.0	0.7	20.1	6.3	0.2

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	620 min	15 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.5 x 350	60-80	 AC (70 OCV) /DCEP Flat butt and fillet welds only  REDRYING CONDITION: 250-300°C for minimum 1 hr.
3.15 x 350	80-120	
4.0 x 350	110-160	
5.0 x 450	150-200	

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kg each.