308L

Standards :

	:	
AWS A5.4	:	E308L-16
	:	

Chemical Composition of Weld Metal- % (Typical) :

Mn	Cr	Mo	Ni
1.2	19.5	0.1	10.0

Mechanical Properties :

Yield Strength Mpa [2]	Tensile Strength Mpa [2]	Impact Strength(-47)	Elongation on 5d
390	620	> J	35%

Typical Base Material Grades :

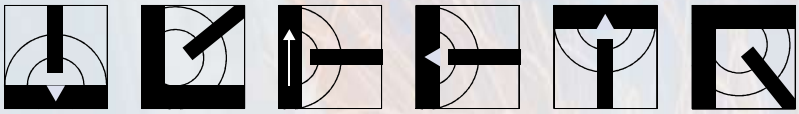
Features and Applications :

308L permits welding at the lowest possible amperage in flat, vertical, horizontal, or overhead positions. Deposition is fast and smooth with low splatter and good slag detachability.
Use for joining or cladding of 18-8 chrome nickel stainless steel requiring similar deposit as the base metal. Ideal for steel types 301, 302, 304, 305, 308, 321, and 347.

Procedures

To avoid heat accumulation, keep a short arc and use low amperage with stringer bead technique. Remove slag after each pass. On DC equipment use positive polarity. On long seams, tack at short intervals to reduce distortion.
Re-Drying of electrodes should be 1 hour at 350 Degrees C

Welding Positions :



Current Type :

D.C. (-) or AC

Operating Data :

Diameter x Length (mm)	Welding Current (A)	Pack Size	Product Code
2.50 x 350	40 - 80	5kg	EI30425
3.20 x 350	60 - 100	5kg	EI30432
4.00 x 350	90 - 140	5kg	EI30440
5.00 x 350	130 - 180	5kg	EI30450