

308L

WELDING ROD FOR STAINLESS STEEL TYPES AISI 201, 202, 301, 302, 304, 304L, 305, 308, 308L. EASY APPLICATION

CLASSIFICATION A.W.S: E-308L-16

APPLICATIONS: This is a welding rod with a special cover. Filler metal consists on low carbon stainless steel 308. This welding rod can be used in all welding positions. Its performance is outstanding in flat welds and in horizontal fillet welds. Weld seams are smooth and look very nice. Slag is easily removed. Since carbon content is low (0.02 as a maximum) it is inter crystalline corrosion resistant. It withstands up to 800°C during oxidizing gas combustion. In a corrosive environment, it is corrosion resistant to inter crystalline action up to 300°C. It retains excellent impact resistance in temperatures of 200°C below zero. There is a wide range of applications for this electrode in the chemical industry, in the food processing industry, in cooking stoves, milk processing plants, textile industries, distilleries, oil refineries, breweries, cryogenic vessels, etc.

CHARACTERISTICS AND PROCEDURE: The resulting filler metal has good corrosion resistance. Its low carbon content decreases carbide precipitation. The arc starts easily, welding progresses fast and there is no spatter. Slag peels off on its own. Clean the joint area to remove dirt, scales, grease and rust. Use reverse polarity. Keep the arc short. Do not let the electrode too close to the surface. Tilt the welding rod slightly in the same direction of the welding. Make straight weld seams without weaving. For vertical welds, use sizes up to 4 mm (5/32") and a low amperage. Remove slag between one pass and the next.

TENSILE RESISTANCE:	5,835 KG./CM2 (83,000 PSI)
BRINELL HARDNESS:	205 BHN
ELONGATION:	44%
FERRITE No.:	8
POSITIONS:	ALL
CURRENT:	AC or DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %					SIZES	AMPERAGE
C	Mn	Si	Cr	Ni		
0.02	0.60	0.60	19.0	10.0	2.38 mm-3/32"	50-70
					3.25 mm - 1/8"	80-100
					4.0 mm - 5/32"	110-130
					5.0 mm - 3/16"	140-170