FINE E - 308L

AWS A/SFA 5.4	E 308 L - 16
IS 5206	E 19.9 LR 26

APPLICATION :-

For Welding ASTM/ASME 304,304L, 304LN, Cast CF3, CF8, food brewery and chemical process vessels, pipelines and nuclear engineering. Type 301, 302 and 303. Also suitable for welding stainless steel kitchen equipment, petrochemical, power and pharmaceutical industries.

CHARACTERISTICS ON USAGE :-

A medium heavy coated, rutile type AC/DC electrode designed for the welding of low carbon 18%Cr/10%Ni, type 304L, 304 austenitic stainless steel. Operability is excellent with a low spatter arc, producing a smooth weld bead surface and self – releasing slag. The Electrode deposits X- ray quality weld metal.

NOTES ON USAGE :-

Short and intermittent welding is to be preferred to avoid overheating and distortion.

Typical Mechanical Properties of weld metal

Tensile Strength MPa	Yield Stress MPa	Elongation (%) (L = 4D)	Charpy V – notch impact strength	
			Temp	Joules
520 Min	380 - 500	35 - 45	0° C	60 - 100

Redrying : - 250° C / 2 hrs., Before Use

Typical Chemical Composition of weld metal

C	Mn	Sl	Cr	Ni	S	P	Cu	Fe
0.04 max	0.4-1.6	0.30-0.60	18-21	9-11	0.03 max	0.04 max	0.50 max	10%

Welding Currents

2.50mm	3.15mm	4mm	5mm
50-75	80-100	110-140	150-180

Packing

WIRE	CONTAINT
2.50 X 350 M.M.	2 Kg. x 5 Pkt. = 10
3.15 X 350 M.M.	2 Kg. x 5 Pkt. = 10
4.00 X 350 M.M.	2 Kg. x 5 Pkt. = 10
5.00 X 350 M.M.	2 Kg. x 5 Pkt. = 10