

SUPER 308L (E 308L - 16)

AWS : SFA 5.4, E 308L - 16

IS : E 19 - 9 LR - 16

Applications

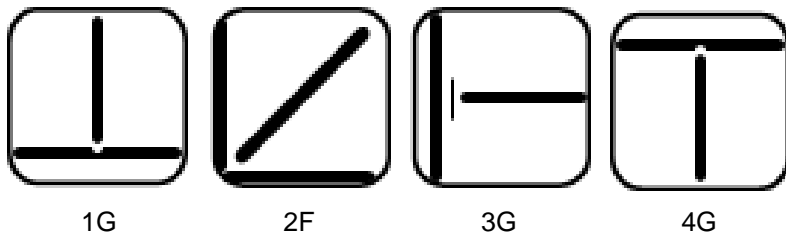
For welding of household furniture industries, milk and soap industries , Hospital apparatus, nuclear plant. Food stuff and chemical process industries. Ideally suited for welding of stainless steel of AISI grade 301, 302, 304, 304L, 308, 308L composition.

Characteristics on Usage

An extra low carbon lime titania all position 18 Cr - 9 Ni stainless steel electrode specially designed for operating on Low OCV welding machines. Which is highly resistance to intergranular corrosion, cracking, oxidation and scaling. Very smooth running with smooth removal of slag leaving a uniform and fine rippled bead characterized by excellent all round performance.

Notes On Usage

- ✍1) It is mostly effective to protect with welding, keeping the arc as short as possible in flat position .
- ✍2) Remove dirt such as oil and dust from groove.
- ✍3) Dry the electrode at 350°C for 60 Min- before use .

Welding Positions**Chemical Composition Of Weld Metal**

| C% | Mn% | Si% | S% | P% | Cr % | Ni % |
|-----------|------------|----------|-----------|-----------|-------------|------------|
| 0.040 Max | 0.50 - 2.0 | 1.00 Max | 0.030 Max | 0.040 Max | 18.0 - 21.0 | 9.0 - 11.0 |

Mechanical Properties Of Weld Metal

| U.T.S. (N/mm ²) | ELONGATION (L = 4d) % |
|--------------------------------|----------------------------|
| 520 Min | 35 % Min |

Packing and Welding Current

| SIZE (mm) | KG PER PACKET | KG PER CARTON | Current (Amps) | In Amps |
|-------------|---------------|---------------|----------------|-----------|
| 2.50 x 350 | 2 | 10 | AC / DC (+) | 45 – 85 |
| 3.15 x 350 | 2 | 10 | | 85 – 115 |
| 4.00 x 350 | 2 | 10 | | 100 – 140 |
| 5.00 x 350 | 2 | 10 | | 140 – 180 |

Packing

Vaccum packing