

E308L-16

AWS A5.4 E308L-16
ISO3581-A-E19 9 L R
GB/T 983 E308L-16

Description:

A rutile type stainless steel electrode with extra low C content ($\leq 0.04\%$) designed to weld stainless steels with working temperature under 300°C , such as SUS304, etc. Excellent operation properties and pores resistance, great mechanical and intercrystalline corrosion resistance performance.

Welding Position:



Diameters:

1.6mm, 2.0mm, 2.5mm, 3.2mm, 4.0mm, 5.0mm.

Typical Mechanical Properties:

Tensile strength(MPa):	610
Yield strength(MPa):	--
Elongation(%):	41

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0.021	0.72	0.02	0.005	0.62	9.75	19.22	0.13	0.25

Welding Current:(AC/DC \pm)

Diameter(mm)	2.5	3.2	4.0	5.0
Current/A	F/H 60-80	80-120	100-150	140-180
Current/A	V/OH 40-70	60-100	80-130	-

Note:

- 1.The electrodes should be baked 1 hours in $300-350^{\circ}\text{C}$ before using.
2. Welding in short arc, and swing scope should not excess 2.5 times of the electrode diameter.