

Descriptions

EQUIVALENT E308L-16 is a titania type electrode. Preheating and post weld heat treatment (PWHT) are not necessary. It is suitable for welding of AISI 304L, and AISI 321 steel.

Notes on usages:

1. Dry the electrodes at 250°C for 60 minutes before use.
2. Clean up the contaminations to prevent the intergranular corrosion.

Classification

AWS A5.4 E308L-16

JIS Z3221 ES308L-16

EN E19 9 L R 12

Typical Chemical Composition (All Weld Metal), weight %

C	Mn	Si	P	S	Cr	Ni			
0.032	1.32	0.45	0.012	0.010	18.42	9.32			

Mechanical Properties (All Weld Metal, as welded)

Yield Strength, N/mm ²	
Tensile Strength, N/mm ²	540
Elongation, %	40
Charpy V-Notch @ -20°C, J	

Operating Data

Diameter	Length	AC/DC+
Ø 2.6mm	300mm	50-80
Ø 3.2mm	350mm	80-110
Ø 4.0mm	350mm	100-140
Ø 5.0mm	350mm	140-180