

Classifications

EN IOS 3581-A:2012	: E 19 9 L R 12	KS D 7014	: E308L-16
EN IOS 3581-A:2012	: ES308L-16	JIS Z 3221	: ES308L-16
AWS A5.4-06	: E308L-16		

Description

- Covering is lime titania type for welding of 18%Cr-8%Ni stainless steel. (AISI 301, 302, 304, 308)
- Excellent welding efficiency because of high deposition rate.
- Remove water, rust, oil and all foreign matters from the groove prior to welding.
- Preheating is not necessary in general.
- Redry the electrode at 250-350°C for 30-60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	Cu	FN
0.03	0.73	0.65	0.028	0.012	10.07	18.86	0.21	0.30	5.3

* FN : WRC 1992

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS)	T.S	El.	IV (J)		Remarks
	(MPa)	(MPa)	(%)	-20°C	-196°C	
AWS A5.4		min. 520	min. 35			
EN ISO 3581-A	min. 320	min. 510	min. 30			
Example	430	600	44	65	25	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.0	2.6	3.2	4.0	5.0
Length	(mm)	250	300	350	350	350
Amp.	F	40~50	55~80	90~130	110~150	140~180
(A)	V · OH	35~45	40~60	70~90	90~130	-

Approvals

ABS	BV	GL	LR
E308L-16	UP	4306	304Lm

* Others : CWB, TUV, CE