

Classification

AWS A5.4

E308L-16

Features & Benefits

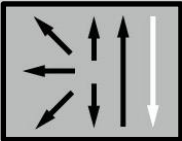

- Low carbon ,austenitic stainless steel stick electrode with rutile coating
- For application in all branches of industry, where same type steels ,including higher carbon and ferritic 13% chrome steels, are welded.
- Designed to produce first class weld deposits with reliable CVN toughness values.
- 100% radiography quality welds with very good root pass and positional welding characteristics.
- Excellent welding properties with DC power and high resistance to hot cracking in the weld metal.
- Good gap bridging ability, easy weld pool and slag control as well as easy slag removal even in narrow preparations resulting in clean bead surfaces and minimum post weld cleaning.
- Good resistance to intergranular corrosion. .
- Exceptional positional welding capacity (Good control in positional welding) and self-releasing slag are of significant economic importance.

Typical Composition of All-weld Metal

C	Si	Mn	P	S	Cr	Ni
0.025	0.70	0.60	0.03	0.02	19.0	10.0

Mechanical Properties of All-weld Metal

Heat treatment condition	Yield strength	Tensile strength	Elongation (L ₀ =4d ₀)	FN
	MPa	MPa	%	WRC-92
As Welded	480	600	40	6

Position	Polarity
	
Available Sizes Diameter x Length (mm) 2.50 x 350 3.15 x 350 4.00 x 350 5.00 x 350	Kg./Pack 2Kg/Pack X 5 = 1 Box