ROWELD- 308L

LOW CARBON STAINLESS STEEL ELECTRODE WELDING
FOR MAXIMUM RESISTANCE TO CORROSION

BASIC ALLOY: MN, CR, NI
AWS/SFA-5.4: E308L-16
EN ISO: 3851-A E 199 LR 32

KEY FEATURES:

An extra low carbon 19/10 stainless steel electrode with properties like resistance to oxidation, resistance to cracking at high temperature. The extra low carbon decreases the possibility of intra-granular corrosion. The electrode gives smooth arc, fine bead appearance and shiny finish

APPLICATIONS

- Suitable for joining AISI 301L, 302L, 304L and 308L steel having 18Cr/8Ni with low carbon content
- Welding for clad ste1) Overlays in Un-alloyed, low alloy steels etc..
- els of similar composition

RE-DRY CONDITION:

- Re-Dry the electrode at 250°Cfor one hour before use.

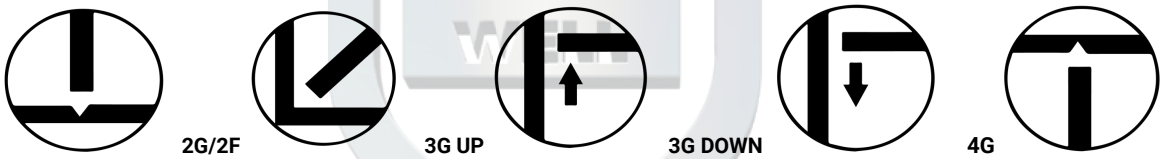
CHEMICAL COMPOSITION:

C	Mn	Si	S	P	Cr	Ni
0.04 max.	0.50-2.50	1.00 Max	0.035 Max	0.040 Max	18.00-21.00	9.00-11.00

MECHANICAL PROPERTIES:

UTS (N/mm)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @	FERRITE (FN)
520-660	35-45	+20C : 60-100 J	3-10

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+/ AC) Amps	Kg/pkt.	Kg/Case
2.00	5/ 64"	40-60	1.5	7.5
2.50/ 2.40	3/ 32"	50-80	2	10
3.15/ 3.20	1/ 8"	75-100	2	10
4.00	5/ 32"	110-140	2	10
5.00	3/ 16"	150-180	2	10