

E 308L-17

STAINLESS STEEL STICK WELDING ELECTRODE

Classification : AWS: A5.4 E 308L-17

Description : Stainless steel welding stick electrodes with extra low carbon 19% Cr & 9% Ni for welding of low carbon 18/8 stainless steel and several austenitic steels. The electrodes gives smooth arc, fine bead appearance and shiny finish. Slag removal is easy. Excellent corrosion and scaling resistant. Weld metal is of radiographic quality.

Typical Application :

- Suitable for welding 18/8 Cr/Ni steel such as 301L, 302L 304L and 308L steel having low carbon Content.
- Typical application include in boilers, refineries
- Build up application on stainless steel job
- Turbines, oil & gas sectors, fertilizer plant, chemical industries

Re- Dry Condition : Re-Dry the electrode at 300°C for 1 hrs, for best results.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Ni	Cr	S	P	Mo	Cu
0.040	0.5-2.5	1.0	9 – 11	18 – 21	0.030	0.040	0.75	0.75

(Single value maximum)

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	Elongation %	CHARPY “V” NOTCH IMPACT AT
>380	520 min.	35 min.	+20 ⁰ C : >80 Joules

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+/AC 70V)	kg/pkt.	kg/Case
2.50/2.40	3/32”	50-90	2	10
3.15/3.20	1/8”	70-120	2	10
4.00	5/32”	100-150	2	10
5.00	3/16”	140-180	2	10

Tailor made packing available on request