



E308L-16

MAARS
Weld Company Limited

BASIC ALLOY Mn, Cr, Ni

CLASSIFICATION:

EN ISO 3851-A

AWS /SFA 5.4

APPROVALS

E19 9 LR32

E308L-16

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KEY FEATURES:

- An extra low carbon 19/10 stainless steel electrode
- 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

WELDING POSITION:



AC(70 OCV)/ DCEP

TYPICAL APPLICATIONS:

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

REDRYING CONDITION: 250 – 300 ° C for minimum 1 hr

CHEMICAL COMPOSITION OF UNDILUTE WELD METAL:

	C	Mn	Si	S	P	Cr	Ni
Specification	0.04 max	0.50- 2.50	1.0 max	0.03 max	0.04 max	18.0- 21.0	9.0- 11.0

MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	UTS, Mpa	FERRITE (FN)	EL%	CVN Impact at -20°C
As Weldec	520- 660	3- 10	35- 45	60- 80J

PARAMETERS - PACKING DATA:

Size(mm) (Dia)	Current Condition (DC+/AC) Amps	kg. /pkt.	kg. /Case
2.00	40- 60	1.5	7.5
2.50/ 2.40	50- 80	2	10
3.15/ 3.20	75- 100	2	10
4.00	110- 140	2	10
5.00	150- 180	2	10

Customer packing on request