



KING STAINLESS 308L

STAINLESS STEEL (Austenitic Steel)



Stainless steel Electrode for welding of all 18/8 type stainless steel.

CLASSIFICATION : AWS A/SFA 5.4

E 308L-16

KEY FEATURES :

- Rutile type coating
- Smooth and stable arc
- Minimal Spatter
- Self peeling slag
- Excellent welder appeal
- All position capability
- Radiographic quality weld
- Results in welds of excellent corrosion and scaling resistance

WELDING POSITION :



AC (50 OCV) /DCEP

TYPICAL APPLICATIONS :

- Welding Cr-Ni steels represented by AISI 301, 302, 304, 304L, 308 and 308L
- For cladding applications

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

C	Mn	Si	Cr	Ni	S	P
0.04 max	0.5-0.25	1.0 max	18.0-21.0	9.0-11.0	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

Condition	UTS, MPa	EL%
As Welded	520 min	35 min

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.0 x 300	35-45	2	5	10
2.5 x 350	55-75	2	5	10
3.15 x 350	85-100	2	5	10
4.0 x 350	110-140	2	5	10