

S-308L.15

Type : Basic

Conformances

AWS A5.4/ ASME SFA5.4 E308L-15

EN ISO 3581-A-E 199 L B

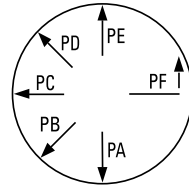
Applications

- Stainless steel(18%Cr-8%)

Features

- Good resistance to corrosion and oxidizing environments
- Easy to remove slag
- Low spatter
- Good bead appearance

Welding Position



Current

DC +

Redrying Conditions

350°C (662°F) X 1hr

Diameter / Packaging

| Diameter mm (in) | Length mm (in) | P.V.C | |
|---------------------|-------------------|-------------------------|-----------------------|
| | | packet 2.5kg(5.5lbs) | carton 10kg(22lbs) |
| 2.6 (3/32) | 300 (12) | ✓ | |
| 3.2 (1/8) | 350 (14) | ✓ | |
| 4.0 (5/32) | 400 (16) | ✓ | |
| 5.0 (3/16) | 400 (16) | ✓ | |

Typical Chemical Composition of All-Weld Metal (%)

| C | Si | Mn | P | S | Cr | Ni |
|------|------|------|-------|-------|------|-----|
| 0.03 | 0.20 | 1.20 | 0.015 | 0.010 | 19.3 | 9.9 |

Typical Mechanical Properties of All-Weld Metal

| TS MPa(lbs/in ²) | EL (%) |
|---------------------------------|-----------|
| 600 (87,000) | 48 |

Typical Welding Parameters / Amp.(A)

| Diameter mm (in) | 2.0 (5/64) | 2.6 (3/32) | 3.2 (1/8) | 4.0 (5/32) | 5.0 (3/16) |
|------------------|------------|------------|-----------|------------|------------|
| Length mm (in) | 300 (12) | 300 (12) | 350 (14) | 400 (16) | 400 (16) |
| F & HF | 25-55 | 50-85 | 70-115 | 95-145 | 135-180 |
| V-up, OH | 20-50 | 45-80 | 65-110 | 85-135 | - |