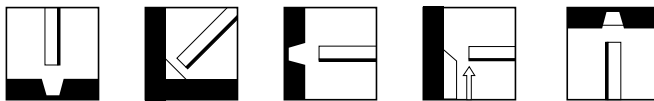


**Classifications**

EN 1600:1997	: E 19 9 L R 12	KS D 7014	: E308L-16
AWS A5.4-06	: E308L-16	JIS Z 3221	: ES308L-16

**Description**

- Covering is lime titania type for welding of 18%Cr-8%Ni stainless steel. (AISI 301, 302, 304, 308)
- Excellent welding efficiency because of high deposition rate.
- Remove water, rust, oil and all foreign matters from the groove prior to welding.
- Preheating is not necessary in general.
- Redry the electrode at 250~350°C for 30~60 minutes prior to use.

**Welding positions****Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	Cu
0.03	0.80	0.84	0.023	0.016	9.6	19.3	0.2	0.3

**Typical mechanical properties of all-weld metal**

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.4		min. 520	min. 35	
EN 1600	min. 320	min. 510	min. 30	
Example	430	600	44	AW

\* AW : As-Welded

**Sizes available and recommended currents (AC or DC +)**

Dia.	(mm)	2.0	2.6	3.2	4.0	5.0
Length	(mm)	250	350	350	350	350
Amp. (A)	F V · OH	40~50 35~45	55~80 40~60	90~130 70~90	110~150 90~130	140~180

**Approvals**

ABS	BV	GL	LR
E308L-16	UP	4306	304Lm

\* Others : CWB, TÜV, CE