

For Low Carbon 18%Cr - 8%Ni Stainless Steel

APPLICATIONS

Welding of SUS304L type austenitic stainless steel.

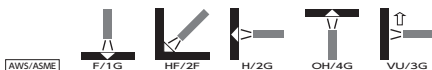
CHARACTERISTICS

S-308L·R is a Low Carbon-19%Cr-9%Ni covered electrode

GUIDELINES FOR USAGE

1. Welding is operated in either AC or DC electrode positive polarity.
2. Electrodes should be dried at 150~250°C for 60 minutes before use.
3. Dirt such as oil, grease and dust should be completely removed from groove.
4. Preheat is not necessary, interpass temperature should be less than 150°C
5. Excessively wide weaving may cause welding defects. Keep weaving width to less than 2.5 times electrode diameter. Arc length should be kept as short as possible.

WELDING POSITION



■ TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

C	Si	Mn	P	S	Ni	Cr	Mo	Cu	Other
0.03	0.28	1.55	0.034	0.007	9.80	19.00	0.02	0.02	—

■ TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield Strength, MPa	Tensile Strength, MPa	Elongation, %	Charpy 2V-notch at 0°C, J
385	548	47	95

■ SIZES & RECOMMENDED CURRENT RANGE<AC or DC(+)>

Diameter (mm)		2.0	2.6	3.2	4.0	5.0
Length (mm)		250	300	350	350	350
Current A	F/H-fillet	45~50	55~70	80~100	110~140	140~170
	V-up, OH	35~45	45~65	70~80	100~130	—

Identification color: End-Red