

For 18%Cr-8%Ni Stainless steel

APPLICATIONS

Welding of 18%Cr-8%Ni austenitic stainless steel for chemical apparatus, containers and plants,

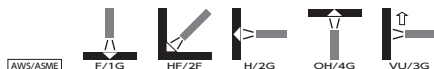
CHARACTERISTICS

S-308 R is a lime-titania type stainless steel electrode depositing 19%Cr-9%Ni metal. Slag is easy to remove, arc is stable, spatters are few and bead appearance is beautiful.

GUIDELINES FOR USAGE

1. Electrodes should be redried at 150~250°C for 60 minutes before use.
2. Dirt such as oil, grease and dust should be completely removed from groove.
3. 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
0.05	0.36	1.35	0.020	0.008	9.8	19.2

■ TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Tensile Strength, MPa	Elongation, %	Creep-rupture Strength (as welded, 650°C×1,000h), MPa
610	42	130

■ 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	F	45~65	55~95	75~125	100~160	150~220
A	V-up, OH	40~60	50~85	65~105	85~135	—

Identification color: End-yellow, secondary-yellow