

Stick electrode

Features: ■ Applicable for 304L type steel

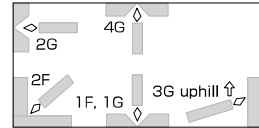
Classification: AWS A5.4 E308L-16

Redrying Conditions: 150~200°Cx0.5~1h

Identification color: 1st Red

Polarity: AC, DCEP

Welding Positions:



Packaging data

| φ mm | Length mm | kg/pack | kg/carton | g/piece | carton mm |
|------|-----------|---------|-----------|---------|------------------|
| 2.0 | 250 | 2 | 20 | 11 | 300W, 125H, 280L |
| 2.6 | 300 | 2 | 20 | 20 | 300W, 100H, 330L |
| 3.2 | 350 | 5 | 20 | 36 | 175W, 115H, 380L |
| 4.0 | 350 | 5 | 20 | 55 | 175W, 130H, 380L |
| 5.0 | 350 | 5 | 20 | 82 | 175W, 130H, 380L |

Composition (all-weld metal mass%)

| | Typical (AC) | Guaranty ^a |
|-----------|--------------|-----------------------|
| C | 0.03 | 0.04 |
| Si | 0.38 | 1.00 |
| Mn | 1.5 | 0.5~2.5 |
| P | 0.02 | 0.04 |
| S | <0.01 | 0.03 |
| Ni | 9.6 | 9.0~11.0 |
| Cr | 20.3 | 18.0~21.0 |
| Mo | 0.14 | 0.75 |
| Cu | 0.05 | 0.75 |

Note: ^aSingle values are maximum.

Welding parameters (A)

| φ mm | 1F, 1G, 2F, 2G | 3G uphill, 4G |
|------|----------------|---------------|
| 2.0 | 50~75 | 45~65 |
| 2.6 | 75~95 | 70~90 |
| 3.2 | 85~120 | 80~115 |
| 4.0 | 110~160 | 90~140 |
| 5.0 | 150~200 | - |

All-weld mechanical properties

| | Typical (AC) | Guaranty |
|---------------------|--------------|----------|
| 0.2%YS (MPa) | 410 | - |
| TS (MPa) | 580 | 518min. |
| El on 4d (%) | 48 | 30min. |
| IV 0°C (J) | 78 | - |

Approvals

| | |
|---------------|---------------|
| LR | 304L m (CHEM) |
| BV | UP (E308L-16) |
| DNV-GL | VL308L |
| NK | KD308L |