

## Stick electrode

**Features:** ■ Suitable for 18%Cr-8%Ni steel for cryogenic temperature service

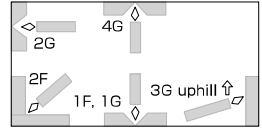
**Classification:** AWS A5.4 E308L-16

**Redrying Conditions:** 150~200°Cx0.5~1h

**Identification color:** 1st Red, 2nd Yellow

**Polarity:** AC, DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	18	300W, 100H, 330L
3.2	350	5	20	33	175W, 115H, 380L
4.0	350	5	20	51	175W, 130H, 380L
5.0	350	5	20	79	175W, 130H, 380L

## Composition (all-weld metal mass%)

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.03	0.04
<b>Si</b>	0.46	1.00
<b>Mn</b>	2.2	0.5~2.5
<b>P</b>	0.02	0.04
<b>S</b>	<0.01	0.03
<b>Ni</b>	10.3	9.0~11.0
<b>Cr</b>	18.8	18.0~21.0
<b>Mo</b>	0.05	0.75
<b>Cu</b>	0.05	0.75

Note: <sup>a</sup> Single values are maximum.

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	50~85	45~80
3.2	70~115	65~110
4.0	95~145	85~130
5.0	135~180	-

## All-weld mechanical properties

	Typical (AC)	Guaranty
<b>0.2%YS (MPa)</b>	370	-
<b>TS (MPa)</b>	540	518min.
<b>EI on 4d (%)</b>	51	35min.
<b>IV -196°C (J)</b>	52	34min.

## Approvals

<b>ABS</b>	MG (AWS 5.4 E308L-16)
<b>LR</b>	304L m (CRYO)
<b>DNV-GL</b>	VL308L, MG
<b>BV</b>	308L BT
<b>NK<sup>a)</sup></b>	KD308

Note: <sup>a)</sup> AC