

Stick Electrode for Stainless Steel

KS-308L

Classification

AWS A 5.4	E308L-16
JIS Z3221	ES308L-16
EN 3581-A	E 19 9 L R
GB T 983	E308L-16

Type of coating: Lime titania type

Applications and Features

- (1) It provides excellent weldability, easy slag removal and smooth beads.
- (2) Low carbon weld metal has lower carbon contents and provides better corrosion resistance.
- (3) It is suitable for welding 18%Cr-8%Ni steel (AISI 304,304L) and 19.5%Cr-10Ni steel (AISI 347).

Welding Position

All Positions

Welding Instruction

- (1) Please refer to Appendix H for re-drying instructions.
- (2) For other instructions and information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S	Cr	Ni
0.028	0.60	1.30	0.014	0.008	19.28	9.75

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %
540(55.1)	390(39.8)	45

Size and Suggested Operating Range (AC or DC+)

Diameter x Length (mm)	2.0x250	2.6x300	3.2x350	4.0x350	5.0x350	
Amp	F/H-Fillet	35~55	50~85	80~120	100~150	140~200
	V-up/OH	30~50	45~85	70~110	90~135	—