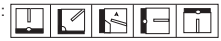
SMAW For Stainless Steel

STAINARC 308L

CLASSIFICATION : AWS A5.4 E308L-16

JIS Z3221 D308L-16

WELDING POSITIONS : 

- **Rutile / Moisture Resistance Coating**
- **All Positional, Low C Deposit**
- **For The Critical Welding Of Type 304 and 304L Stainless Steel**

Approval (Pending)
Lloyds Register Of Shipping

DESCRIPTION AND APPLICATIONS

New generation STAINARC 308L is an extra low carbon, rutile type electrode exhibiting superior all positional (except vertical down) performance with an improved moisture resistant coating for weld metal of high radiographic integrity. The smooth arc action of STAINARC 308L - 16 together with low spatter and excellent slag control / detachability promote exceptional weld appearance and profile. Other features include high arc stability and easy restriking.

STAINARC 308L deposits a straight 19% Cr / 10% Ni filler metal to meet the requirements for welding AISI type 304 and 304L stainless steels in critical applications. STAINARC 308L is also suitable for the general purpose of welding other stabilized and non-stabilized 300 series stainless steels.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)				
C	Mn	Si	Cr	Ni
0.025	0.7	0.7	19.0	10.0

FERRITE NUMBER
3.0 - 7.5 FN•

• using Severn Gauge

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES•			
YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
450 N/mm^2	600 N/mm^2	40%	75J av @ -20˚C

• in “as welded” condition.

OPERATIONAL AND PACKAGING DATA					
ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE • (amps)	PACKAGING (kg)		
			PKT		CTN
2.0	300	30 - 50	2	4	16
2.6	300	50 - 75	2.5	5	20
3.2	350	75 - 110	2.5	5	20
4.0	350	110 -150	2.5	5	20

• Recommended for DC + or AC (minimum 45 OCV) operation