

# SUNWELD 308L

Stainless Steel Electrode



## CLASSIFICATION

AWS A 5.4 : E 308L

IS 5206-83 : E19.9 LR 26

## CHARACTERISTICS

SUNWELD 308L-16 is a stainless steel electrode depositing an extra low carbon 19 Cr-10 Ni weld metal which has excellent resistance to inter-granular corrosion. The weld metal has higher resistance to cracking, oxidation & scaling at elevated temperatures. It possesses excellent weld ability in all positions

**Special Characteristic: Delta Ferrite 5 to 10 FN**

## APPLICATIONS

Ideally suited for welding austenitic stainless steels, wrought & cast materials of similar composition, welding of AISI 304, 304L, 308L & their equivalent for overlays and surfacing applications etc. Widely used in industries like food & beverage, chemicals etc.

## CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

C	Mn	Si	Cr	Ni	S	P
0.032	1.4	0.45	19.4	10.02	0.009	0.014

## MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Ultimate Tensile Strength	Elongation
566.0 N/mm <sup>2</sup>	38.4 %

## CURRENT RANGE & PACKING DATA:

Size (mm)	Length (mm)	Current(Amp) AC or DC(+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard box
2.50	350	60-80	2 Kg	10 Kg
3.15	450	80-100	2 Kg	10 Kg
4.00	450	100-140	2 Kg	10 Kg
5.00	450	140-180	2 Kg	10 Kg

## RECOMMENDATIONS:

Re-dry the electrodes at 200°C for one hour. Use stainless steel wire brush for cleaning the welds.