



JACKSUN - 308L STAINLESS STEEL

Stainless steel Electrode for welding of all 18/8 type stainless steel.

CLASSIFICATION:

AWS A/SFA 5.4

APPROVALS

E308L-16

CE / BIS/IBR/BHEL/IRS/

KEY FEATURES :

- Rutile type -medium coated, all-position general purpose electrode operates on both AC & DC.
- Smooth and stable arc
- Minimal Spatter
- Self-peeling slag.
- Excellent welder appeal
- Radiographic quality weld
- Results in welds of excellent corrosion and scaling resistance

WELDING POSITION:

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AC (70 OCV)/ DCEP

TYPICAL APPLICATIONS:

- Welding Cr-Ni steels represented by AISI 301, 302, 304, 304L, 308 and 308L
- sheet metals, structures.
- For cladding applications

REDRYING CONDITION: 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL Wt% :

	C	Mn	Si	S	Cr	Ni	P
Specification	0.15 max	0.25	1.0 max	0.03 max	18.0-20.0	9.0-10.5	0.04 max

MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	UTS, Mpa	YIELD STRENGTH	EL%	CVN Impact at -20°C
As Welded	540-620	360 - 480	30 - 40min	60 - 80 J

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	Wt./Carton kg	Carton/Box	Approx. wt. of 1000 pcs, Kg.
3.15 x 350	55-75	2	5	10
4.0 x 450	140-190	2	5	10