

Stainless Steel SMAW Electrodes

KE308L

AWS A5.4 E308L-16
JIS Z 3221 ES308L-16

Product Features:

- Low carbon lime Titanium oxide type covered electrode for low carbon content stainless steel.
- Good arc stability, easy slag removal and less spatter loss.
- Good bead appearance, crack resistance and corrosion resistance.

Applications:

- Suitable for welding of low carbon content 18Cr-8Ni stainless steel such as SUS304 and 304L.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo
0.03	0.80	0.66	9.80	19.3	0.02

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %
556	47.7

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.0/250	2.6/300	3.2/350	4.0/350	5.0/350
Flat position	30~55	60~85	85~120	115~150	150~200
Vertical / overhead position	30~50	50~70	75~105	95~130	----

Note:

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