

Rutile electrode

SUPERSTAINLESS 308L

Classification	AWS A 5.4: E 308L-16	DIN 8556: E 19 9 LR 23
	DIN EN 1600: E 19 9 LR R 32	Werkstoff Nr: 1.4316

Description and applications

Low carbon Rutile-basic-coated austenitic stainless steel electrode with approx 8% ferrite. Coating with very low moisture pick up. Soft fusion, without spatters, very easy slag removal, exceptional weld bead appearance, easy restriking. Applied for all 18/8 type stainless steel at service temperatures from -120°C up to +350°C : tubes tanks, heat exchangers, piping systems.

Base materials

Stainless steels for general use:				
UNS	Alloy	EN 10088	Material N ^a	UGINE
S30400	304	X5CrNi18-10	1.4301	UGINOX 18-9, B D, E
S30403	304L	X2CrNi19-11	1.4306	UGINOX 18-10 L
S32100	321	X6CrNiTi18-10	1.4541	UGINOX 18-10 T
S34700	347	X6CrNiNb18-10	1.4550	

All weld metal mechanical properties (typical)

Tensile Strength R _m (N/mm ²)	Elongation %	ISO- V J RT
600	40	55

Typical weld metal Chemical Composition (%)

C	Si	Mn	Cr	Ni	S	P	Mo
< 0.04	<0.90	0.80	>18.0	>9.0	0.015	0.030	---

Amperes (A)

2.5	3.15	4.00	5.00
50-80	80- 110	110- 150	150-180

Welding instruction interpass temperature :< 200°C. Rebaking if necessary 1 hour at 250°C.

